User Manual

Read and understand this manual before using machine.

HOLLOW CHISEL MORTISER

Model Number 25200

C US

STEEL CITY TOOL WORKS

VER. 2.07

Manual Part No. OR71593

THANK YOU for purchasing your new Steel City Hollow Chisel Mortiser. This mortiser has been designed, tested, and inspected with you, the customer, in mind. When properly assembled, used and maintained, your mortiser will provide you with years of trouble free service, which is why it is backed by one of the longest machinery warranties in the business.

This mortiser is just one of many products in the Steel City's family of woodworking machinery and is proof of our commitment to total customer satisfaction.

At Steel City we continue to strive for excellence each and every day and value the opinion of you, our customer. For comments about your mortiser or Steel City Tool Works, please visit our web site at **www.steelcitytoolworks.com** .

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INTRODUCTION

This user manual is intended for use by anyone working with this machine. It should be kept available for immediate reference so that all operations can be performed with maximum efficiency and safety. Do not attempt to perform maintenance or operate this machine until you have read and understand the information contained in this manual.

The drawings, illustrations, photographs, and specifications in this user manual represent your machine at time of print. However, changes may be made to your machine or this manual at any time with no obligation to Steel City Tool Works.

WARRANTY

2 YEAR LIMITED WARRANTY

Steel City Tool Works, LLC (SCTW) warrants this SCTW machinery to be free of defects in workmanship and materials for a period of 2 years from the date of the original retail purchase by the original owner for domestic use. Granite components are warranted for 2 years based on normal use and is void if non SCTW accessories are used that cause the break or chip. Customer must advise SCTW within 30 days for any damage or defect found upon receipt of the product to qualify for the warranty on granite.

The warranty does not cover any product used for professional or commercial production purpose nor for industrial or educational applications. Such cases are covered by our 1 year Limited Warranty with the Conditions and Exceptions listed below.

Conditions and exception:

Warranty applies to the original buyer only and may not be transferred. Original proof of purchase is required.

Warranty does not include failures, breakage or defects deemed after inspection by an Authorized Service Center, (ASC) or agent of, have been directly or indirectly caused by or resulting from improper use, lack of or improper maintenance, misuse or abuse, negligence, accidents, damage in handling or transport, or normal wear and tear of any part or component.

Additionally, warranty is void if repairs or alterations are made to the machine by an unauthorized service center without the direct consent of SCTW

Consumables such as blades, knives, bits and sandpaper are not covered.
Wear items such as drive belt, bearings, switch, are covered for 1 year.

To file a claim of warranty or to find a service center, call toll free 877-724-8665 or email customercare@steelcitytoolworks.net and you must be able to present the original or photo copy of the sales receipt including the serial number from the machine and/or carton.

SCTW will inspect, repair or replace, at its expense and its option, any part that has proven to be defective in workmanship or material, provided that the customer returns the product prepaid to a designated ASC and provides SCTW with a reasonable opportunity to verify the alleged defect by inspection. SCTW will return the product or replacement at our expense unless it is determined by us that there is no defect or that the defect resulted from causes not within the scope of our *warranty in which case we will, at your direction, dispose of or return the product.* In the event you choose to have the product returned, you will be responsible for the handling and shipping costs of the return.

SCTW furnishes the above warranties in lieu of all other warranties, express or implied. SCTW shall not be liable for any special, indirect, incidental, punitive or consequential damages, including without limitation loss of profits arising from or related to the warranty, the breach of any agreement or warranty, or the operation or use of its machinery, including without limitation damages arising from damage to fixtures, tools, equipment, parts or materials, direct or indirect loss caused by and other part, loss of revenue or profits, financing or interest charges, and claims by and third person, whether or not notice of such possible damages has been given to SCTW. Damages or any kind for any delay by or failure of SCTW to perform its obligations under this agreement or claims made a subject of a legal proceeding against SCTW more than one (1) year after such cause of action first arose.

The validity, construction and performance of this Warranty and any sale of machinery by SCTW shall be governed by the law of the Commonwealth of Pennsylvania, without regard to conflicts of law's provisions of any jurisdiction. Any action related in any way to any alleged or actual offer, acceptance or sale by SCTW or any claim related to the performance of and agreement including without limitation this Warranty, shall take place in the federal or state courts in Allegheny County, Pennsylvania.

Warranty registration card must be submitted to SCTW for purpose of proof within 90 days of purchase with a copy of the sales receipt. Failure to do so will, revert the 2 year warranty to 1 year as in the terms stated above. This registration is also needed to facilitate contact in case of a safety recall.

This warranty gives you specific legal rights and you may have other rights which vary in certain States or Provinces.

Note to user
This instruction manual is meant to serve as a guide only. Specification and references are subject to change without prior notice. Check the website www.steelcitytoolworks.com for updated manuals with reference to the VER# located on the front page.

LIMITED WARRANTY – ACCU-SHOP line of bench top tools

Steel City Tool Works, LLC (SCTW) warrants this SCTW ACCU-SHOP machinery to be free of defects in workmanship and materials for a period of 2 years from the date of the original retail purchase by the original owner for domestic use.
Consumables such as blades, knives, bits and sandpaper are not covered.
Wear items such as drive belt, bearings, switch, are covered for 1 year.

The warranty does not cover any product used for professional or commercial production purpose nor for industrial or educational applications. Such cases are covered by our 30 days Limited Warranty with the Conditions and Exceptions listed previously.

WARRANTY CARD

Name _____

Street _____

Apt. No. _____

City _____ State _____ Zip _____

Phone Number _____

E-Mail _____

Product Description: _____

Model No.: _____ Serial No.: _____

NOTE: The **Proof of Purchase** must be submitted along with this card in order to have the Warranty to take into effect. Fail to submit the Proof of Purchase may invalidate your Product Warranty.

The following information is given on a voluntary basis and is strictly confidential.

1. Where did you purchase your STEEL CITY machine?
   Store: _____
   City: _____ Online: _____

2. How did you first learn of Steel City Tool Works?
   ___ Advertisement ___ Mail Order Catalog
   ___ Web Site ___ Friend
   ___ Local Store Other _____

3. Which of the following magazines do you subscribe to?
   ___ American Woodworker ___ Cabinetmaker
   ___ Canadian Woodworking ___ Family Handyman
   ___ Fine Homebuilding ___ Fine Woodworking
   ___ Journal of Light Construction ___ Old House Journal
   ___ Popular Mechanics ___ Popular Science
   ___ Popular Woodworking ___ Today's Homeowner
   ___ WOOD ___ Woodcraft
   ___ WOODEN Boat ___ Woodshop News
   ___ Woodsmith ___ Woodwork
   ___ Woodworker ___ Woodworker's Journal
   ___ Workbench Other _____

4. Which of the following woodworking / remodeling shows do you watch?
   ___ Backyard America ___ The American Woodworker
   ___ Home Time ___ The New Yankee Workshop
   ___ This Old House ___ Woodwright's Shop
   Other _____

5. What is your annual household income?
   ___ $20,000 to $29,999 ___ $30,000 to $39,999
   ___ $40,000 to $49,999 ___ $50,000 to $59,999
   ___ $60,000 to $69,999 ___ 70,000 to $79,999
   ___ $80,000 to $89,999 ___ $90,000 +

6. What is your age group?
   ___ 20 to 29 years ___ 30 to 39 years
   ___ 40 to 49 years ___ 50 to 59 years
   ___ 60 to 69 years ___ 70 + years

7. How long have you been a woodworker?
   ___ 0 to 2 years ___ 2 to 8 years
   ___ 8 to 20 years ___ over 20 years

8. How would you rank your woodworking skills?
   ___ Simple ___ Intermediate
   ___ Advance ___ Master Craftsman

9. How many Steel City machines do you own? _____

10. What stationary woodworking tools do you own?
    Check all that apply.
    ___ Air Compressor ___ Band Saw
    ___ Drill Press ___ Drum Sander
    ___ Dust Collection ___ Horizontal Boring Machine
    ___ Jointer ___ Lathe
    ___ Mortiser ___ Panel Saw
    ___ Planer ___ Power Feeder
    ___ Radial Arm Saw ___ Shaper
    ___ Spindle Sander ___ Table Saw
    ___ Vacuum Veneer Press ___ Wide Belt Sander
    Other _____

11. Which benchtop tools do you own? *Check all that apply.*
    ___ Belt Sander ___ Belt / Disc Sander
    ___ Drill Press ___ Band Saw
    ___ Grinder ___ Mini Jointer
    ___ Mini Lathe ___ Scroll Saw
    ___ Spindle / Belt Sander Other _____

12. Which portable / hand held power tools do you own?
    Check all that apply.
    ___ Belt Sander ___ Biscuit Jointer
    ___ Dust Collector ___ Circular Saw
    ___ Detail Sander ___ Drill / Driver
    ___ Miter Saw ___ Orbital Sander
    ___ Palm Sander ___ Portable Thickness Planer
    ___ Saber Saw ___ Reciprocating Saw
    ___ Router Other _____

13. What machines / accessories would you like to see added to the STEEL CITY line?
    _____
    _____

14. What new accessories would you like to see added?
    _____
    _____

15. Do you think your purchase represents good value?
    ___Yes ___ No

16. Would you recommend STEEL CITY products to a friend?
    ___ Yes ___ No

17. Comments:
    _____
    _____
    _____
    _____
    _____

CUT HERE

FOLD ON DOTTED LINE

PLACE
STAMP
HERE

SteelCityToolWorks

#4 Northpoint Court
Bolingbrook, IL 60440

FOLD ON DOTTED LINE

PRODUCT SPECIFICATIONS

MOTOR

Type	Induction
Continuous duty HP	1/2 HP
Amps	5.6
Volts	120
Hertz	60
RPM	1725 RPM
Chuck type	Keyed
Chuck maximum capacity	3/8”
Chisel sizes	1/4”x 1/4” 5/16”x 5/16” 3/8”x 3/8” 1/2”x 1/2”
Micro-adjust	Yes
Bit holder	Yes
Handle position	Left or right (interchangeable)

PRODUCT DIMENSIONS

Maximum stroke	5”
Chisel center to fence	4”
Under hold down	1” x 4-1/4”
Fence size	14-1/2”x 3”
Base size (without extensions)	17”x 15”
Base size (with extensions)	17” x 35”

OVERALL DIMENSIONS

Height	30-1/2”
Width	15”
Depth	17”
Weight	81 lbs.

SHIPPING DIMENSIONS

Carton type	Box
Length	19-3/4”
Width	16-1/2”
Height	17-1/2”
Gross weight	88 lbs.

ACCESSORIES AND ATTACHMENTS

There are a variety of accessories available for your Steel City Product. For more information on any accessories associated with this and other machines, please contact your nearest Steel City distributor, or visit our website at: **www.steelcitytoolworks.com**.

DEFINITION OF TERMS

Blind Mortise - Joint where the mortise does not go all the way through the stock.

Chipout - Breakage on the exit side of a through mortise.

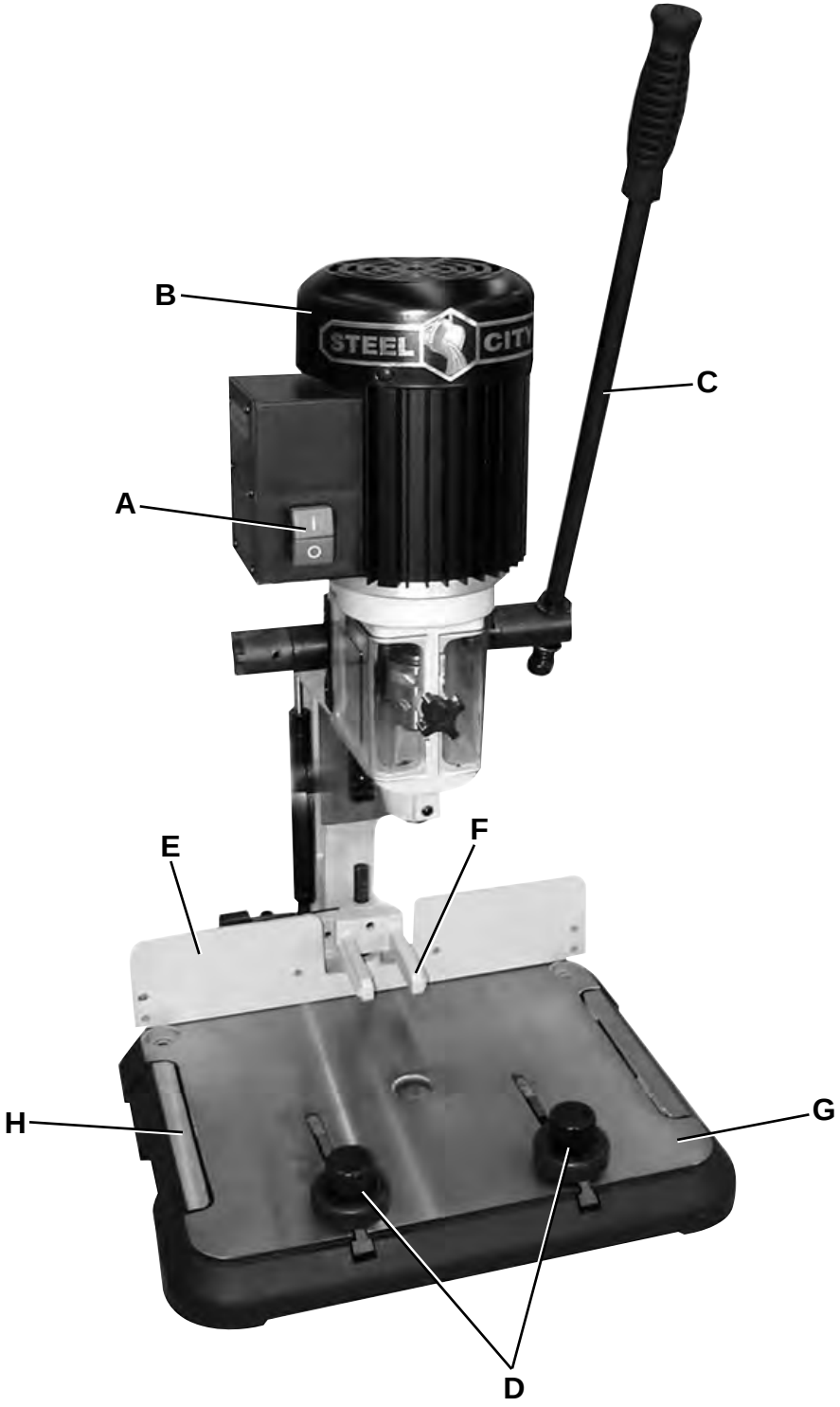
Corner Mortise - Commonly used for frame and panel sections such as raised panel cabinet doors.

Micro Adjust - Assembly which allows the fence to be moved in or out in very small increments.

Tenon - A projection on the end of a workpiece that is inserted into a mortise.

Through Mortise - Joint where the mortise goes completely through the workpiece, allowing the end of the tenon to be exposed.

FEATURE IDENTIFICATION



A) Switch
B) Motor housing
C) Raise/Lower handle
D) Stock rollers
E) Fence
F) Hold down
G) Base/Worktable
H) Extension wings

GENERAL SAFETY

⚠ WARNING

TO AVOID serious injury and damage to the machine, read and follow all Safety and Operating Instructions before assembling and operating this machine.

This manual is not totally comprehensive. It does not and can not convey every possible safety and operational problem which may arise while using this machine. The manual will cover many of the basic and specific safety procedures needed in an industrial environment.

All federal and state laws and any regulations having jurisdiction covering the safety requirements for use of this machine take precedence over the statements in this manual. Users of this machine must adhere to all such regulations.

Below is a list of symbols that are used to attract your attention to possible dangerous conditions.

⚠

This is the international safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

⚠ DANGER

Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.

⚠ WARNING

Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.

⚠ CAUTION

Indicates a potentially hazardous situation, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

CAUTION

CAUTION used without the safety alert symbol indicates a potentially hazardous situation which, if not avoided, may result in property damage.

NOTICE

This symbol is used to alert the user to useful information about proper operation of the machine.

⚠ WARNING

Exposure to the dust created by power sanding, sawing, grinding, drilling and other construction activities may cause serious and permanent respiratory or other injury, including silicosis (a serious lung disease), cancer, and death. Avoid breathing the dust, and avoid prolonged contact with dust. The dust may contain chemicals known to the State of California to cause cancer, birth defects or other reproductive harm.

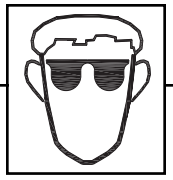
Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement and other masonry products.
- Arsenic and chromium from chemically-treated lumber.

Always operate tool in well ventilated area and provide for proper dust removal. Use a dust collection system along with an air filtration system whenever possible. Always use properly fitting NIOSH/OSHA approved respiratory protection appropriate for the dust exposure, and wash exposed areas with soap and water.

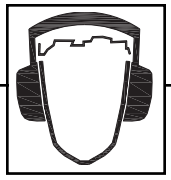
1. To avoid serious injury and damage to the machine, read the entire User Manual before assembly and operation of this machine.

⚠ WARNING



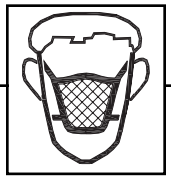
2. **ALWAYS** wear eye protection. Any machine can throw debris into the eyes during operations, which could cause severe and permanent eye damage. Everyday eyeglasses are **NOT** safety glasses. **ALWAYS** wear Safety Goggles (that comply with ANSI standard Z87.1) when operating power tools.

⚠WARNING



3. **ALWAYS** wear hearing protection. Plain cotton is not an acceptable protective device. Hearing equipment should comply with ANSI S3.19 Standards.

⚠WARNING



4. **ALWAYS** wear a NIOSH/OSHA approved dust mask to prevent inhaling dangerous dust or airborne particles.

5. **ALWAYS** keep the work area clean, well lit, and organized. **DO NOT** work in an area that has slippery floor surfaces from debris, grease, and wax.

6. **ALWAYS** unplug the machine from the electrical receptacle before making adjustments, changing parts or performing any maintenance.

7. **AVOID ACCIDENTAL STARTING**. Make sure that the power switch is in the "OFF" position before plugging in the power cord to the electrical receptacle.

⚠WARNING

8. **AVOID** a dangerous working environment. **DO NOT** use electrical tools in a damp environment or expose them to rain or moisture.

⚠WARNING

9. **CHILDPROOF THE WORKSHOP AREA** by removing switch keys, unplugging tools from the electrical receptacles, and using padlocks.

10. **DO NOT** use electrical tools in the presence of flammable liquids or gasses.

11. **DO NOT FORCE** the machine to perform an operation for which it was not designed. It will do a safer and higher quality job by only performing operations for which the machine was intended.

12. **DO NOT** stand on a machine. Serious injury could result if it tips over or you accidentally contact any moving part.

13. **DO NOT** store anything above or near the machine.

14. **DO NOT** operate any machine or tool if under the influence of drugs, alcohol, or medication.

15. **EACH AND EVERY** time, check for damaged parts prior to using any machine. Carefully check all guards to see that they operate properly, are not damaged, and perform their intended functions. Check for alignment, binding or breakage of all moving parts. Any guard or other part that is damaged should be immediately repaired or replaced.

16. Ground all machines. If any machine is supplied with a 3-prong plug, it must be plugged into a 3-contact electrical receptacle. The third prong is used to ground the tool and provide protection against accidental electric shock. **DO NOT** remove the third prong.

17. Keep visitors and children away from any machine. **DO NOT** permit people to be in the immediate work area, especially when the machine is operating.

18. **KEEP** protective guards in place and in working order.

19. **MAINTAIN** your balance. **DO NOT** extend yourself over the tool. Wear oil resistant rubber soled shoes. Keep floor clear of debris, grease, and wax.

20. **MAINTAIN** all machines with care. **ALWAYS KEEP** machine clean and in good working order. **KEEP** all blades and tool bits sharp.

21. **NEVER** leave a machine running, unattended. Turn the power switch to the OFF position. **DO NOT** leave the machine until it has come to a complete stop.

22. **REMOVE ALL MAINTENANCE TOOLS** from the immediate area prior to turning the machine ON.

23. **SECURE** all work. When it is possible, use clamps or jigs to secure the workpiece. This is safer than attempting to hold the workpiece with your hands.

24. **STAY ALERT**, watch what you are doing, and use common sense when operating any machine. **DO NOT** operate any machine tool while tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating power tools may result in serious personal injury.

25. **USE ONLY** recommended accessories. Use of incorrect or improper accessories could cause serious injury to the operator and cause damage to the machine. If in doubt, **DO NOT** use it.
26. Wear proper clothing, **DO NOT** wear loose clothing, gloves, neckties, or jewelry. These items can get caught in the machine during operations and pull the operator into the moving parts. Users must wear a protective cover on their hair, if the hair is long, to prevent it from contacting any moving parts.
27. **SAVE** these instructions and refer to them frequently and use them to instruct other users.
28. Information regarding the safe and proper operation of this tool is also available from the following sources:

    Power Tool Institute
    1300 Summer Avenue
    Cleveland, OH 44115-2851
    www.powertoolinstitute.org

    National Safety Council
    1121 Spring Lake Drive
    Itasca, IL 60143-3201

    American National Standards Institute
    25West 43rd. St, 4th Floor
    New York, NY. 10036
    ANSI 01.1 Safety Requirements
    For Woodworking Machines
    WWW.ANSI.ORG

    U.S. Department of Labor Regulations
    OSHA 1910.213 Regulations
    WWW.OSHA.GOV

PRODUCT SAFETY

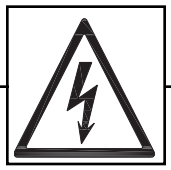
1. Serious personal injury may occur if normal safety precautions are overlooked or ignored. Accidents are frequently caused by lack of familiarity or failure to pay attention. Obtain advice from supervisor, instructor, or another qualified individual who is familiar with this machine and its operations.
2. Every work area is different. Always consider safety first, as it applies to your work area. Use this machine with respect and caution. Failure to do so could result in serious personal injury and damage to the machine.
3. Prevent electrical shock. Follow all electrical and safety codes, including the National Electrical Code (NEC) and the Occupational Safety and Health Regulations (OSHA). All electrical connections and wiring should be made by qualified personnel only.

⚠ WARNING

4. **TO REDUCE** the risk of electrical shock. **DO NOT** use this machine outdoors. **DO NOT** expose to rain or moisture. Store indoors in a dry area.

5. **STOP** using this machine, if at any time you experience difficulties in performing any operation. Contact your supervisor, instructor or machine service center immediately.
6. Safety decals are on this machine to warn and direct you to how to protect yourself or visitors from personal injury. These decals **MUST** be maintained so that they are legible. **REPLACE** decals that are not legible.
7. **DO NOT** leave the unit plugged into the electrical outlet. Unplug the unit from the outlet when not in use and before servicing, performing maintenance tasks, or cleaning.
8. **ALWAYS** turn the power switch “OFF” before unplugging the mortiser.

⚠ WARNING



9. **DO NOT** handle the plug or mortiser with wet hands.

10. **USE** accessories only recommended by Steel City.
11. **DO NOT** pull the mortiser by the power cord. **NEVER** allow the power cord to come in contact with sharp edges, hot surfaces, oil or grease.
12. **DO NOT** unplug the mortiser by pulling on the power cord. **ALWAYS** grasp the plug, not the cord.
13. **REPLACE** a damaged cord immediately. **DO NOT** use a damaged cord or plug. DO NOT USE if the mortiser is not operating properly, or has been damaged, left outdoors or has been in contact with water.

14. **DO NOT** use the mortiser as a toy. DO NOT use near or around children.

15. **ALWAYS WEAR EYE PROTECTION**. Any power tool can throw debris into the eyes during operations, which could cause severe and permanent eye damage. Everyday eyeglasses are **NOT** safety glasses. **ALWAYS** wear Safety Goggles (that comply with ANSI standard Z87.1) when operating power tools.

16. Basic precautions should **ALWAYS** be followed when using any power tool.

17. **DO NOT OPERATE THIS MACHINE** until it is assembled and installed according to the instructions.

18. **OBTAIN ADVICE FROM YOUR SUPERVISOR**, instructor, or another qualified person if you are not familiar with the operations of this power tool.

19. **DO NOT** leave any power tool plugged into the electrical outlet. Unplug it from the outlet when not in use and before servicing and cleaning.

20. **TO REDUCE THE RISK OF ELECTRICAL SHOCK**, do not use outdoors. Do not expose to rain. Store indoors.

21. **FOLLOW** all electrical and safety codes, including the National Electric Code (NEC) and the Occupational Safety and Health Regulations (OSHA). All electrical connections and wiring should be made by qualified personnel only.

22. **CONNECT** power tool to a properly grounded outlet only. See grounding instructions.

23. **SECURE THE MACHINE TO A SUPPORTING SURFACE**. Vibration can cause the machine to slide, walk, or tip over.

24. **NEVER START THE MACHINE** with the drill bit or cutting tool against the workpiece. Loss of control of the workpiece can cause serious injury.

25. **PROPERLY LOCK THE DRILL BIT OR CUTTING TOOL IN THE UNIT** before operating this machine.

26. **DO NOT** attempt to mortise material that does not have a flat surface, unless a suitable support is used.

27. **USE ONLY DRILL BITS, CUTTING TOOLS, OR OTHER ACCESSORIES** with shank size recommended in your instruction manual. The wrong size accessory can cause damage to the machine and/or serious injury.

28. **USE ONLY DRILL BITS OR CUTTING TOOLS** that are not damaged. Damaged items can cause malfunctions that lead to injuries.

29. **ALWAYS** position the hold-down directly over the workpiece to prevent the workpiece from lifting during operation. Loss of control of the workpiece can cause serious injury.

30. **TURN THE MACHINE "OFF" AND WAIT FOR THE DRILL BIT AND CUTTING TOOL TO STOP TURNING** prior to cleaning the work area, removing debris, or removing or securing work-piece. A moving drill bit or cutting tool can cause serious injury.

31. **PROPERLY SUPPORT LONG OR WIDE** workpieces, loss of control of the workpiece can cause severe injury.

32. **NEVER PERFORM LAYOUT, ASSEMBLY OR SET-UP WORK** on the table/work area when the machine is running. Serious injury can result.

33. **TURN THE MACHINE "OFF"**, disconnect the machine from the power source, and clean the table/work area before leaving the machine.

34. **REPLACE** a damaged cord immediately. **DO NOT** use a damaged cord or plug. If the power tool is not operating properly, or has been damaged, left outdoors or has been in contact with water, return it to a Steel City Service Center.

35. **SAVE THESE INSTRUCTIONS**. Refer to them frequently and use them to instruct other users.

ELECTRICAL REQUIREMENTS

TO PREVENT electrical shock, follow all electrical and safety codes, including the National Electrical Code (NEC) and the Occupational Safety and Health Regulations (OSHA). All electrical connections and wiring should be made by qualified personnel only.

TO REDUCE the risk of electrical shock, **DO NOT** use machine outdoors. **DO NOT** expose to rain or moisture. Store indoors in a dry area.

DO NOT connect the machine to the power source before you have completed the set up process.

DO NOT connect the machine to the power source until instructed to do so.

This motor in this machine is designed to run at 115V.

GROUNDING INSTRUCTIONS

⚠WARNING

This machine **MUST BE GROUNDED** while in use to protect the operator from electric shock.

In the event of a malfunction or breakdown, **GROUNDING** provides the path of least resistance for electric current and reduces the risk of electric shock. This machine is equipped with an electric cord that has an equipment-grounding conductor and a grounding plug. The plug **MUST** be plugged into a matching electrical receptacle that is properly installed and grounded in accordance with **ALL** local codes and ordinances.

If a plug is provided with your machine **DO NOT** modify the plug. If it will not fit your electrical receptacle, have a qualified electrician install the proper connections to meet all electrical codes local and state. All connections must also adhere to all of OSHA mandates.

IMPROPER ELECTRICAL CONNECTION of the equipment-grounding conductor can result in risk of electric shock. The conductor with the green insulation (with or without yellow stripes) is the equipment-grounding conductor. **DO NOT** connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if you do not completely understand the grounding instructions, or if you are not sure the tool is properly grounded.

PLUGS/RECEPTACLES

⚠WARNING

- Electrocution or fire could result if this machine is not grounded properly or if the electrical configuration does not comply with local and state electrical codes.
- **MAKE CERTAIN** the machine is disconnected from power source before starting any electrical| work.
- **MAKE SURE** the circuit breaker does not exceed the rating of the plug and receptacle.

The motor supplied with your machine is a 115 volt motor. It is shipped wired for 115 volt application. Never connect the green or ground wire to a live terminal.

This tool is intended for use on a circuit that has an electrical receptacle as shown in Figure 1-1. Figure 1-1 shows a NEMA approved 3-wire, 15 amp electrical plug and receptacle that have a grounding conductor. If a properly grounded electrical receptacle is not available, an adapter as shown in Figure 1-2 can be used to temporarily connect this plug to a 2-contact ungrounded receptacle. The adapter has a rigid lug extending from it that **MUST** be connected to a permanent earth ground, such as a properly grounded receptacle box. **THIS ADAPTER IS PROHIBITED IN CANADA.**

Fig. 1-1

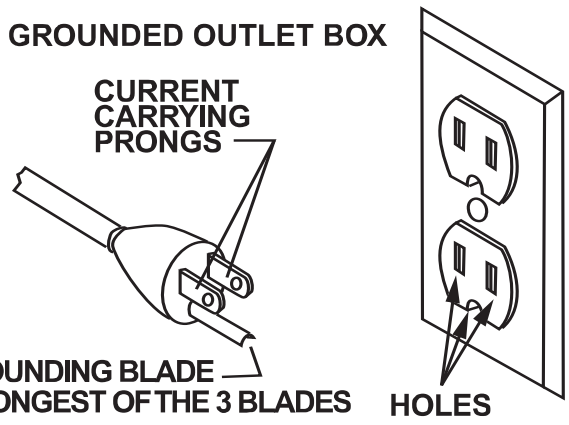
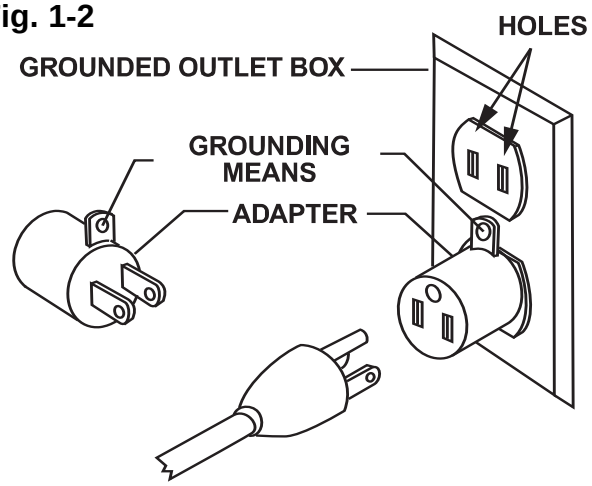


Fig. 1-2



EXTENSION CORDS

⚠WARNING

To reduce the risk of fire or electrical shock, use the proper gauge of extension cord. When using an extension cord, be sure to use one heavy enough to carry the current your machine will draw.

The smaller the gauge-number, the larger the diameter of the extension cord is. If in doubt of the proper size of an extension cord, use a shorter and thicker cord. An undersized cord will cause a drop in line voltage resulting in a loss of power and overheating.

⚠ CAUTION

USE ONLY a 3-wire extension cord that has a 3-prong grounding plug and a 3-pole receptacle that accepts the machine's plug.

If you are using an extension cord outdoors, be sure it is marked with the suffix "W-A" ("W" in Canada) to indicate that it is acceptable for outdoor use.

Make certain the extension cord is properly sized, and in good electrical condition. Always replace a worn or damaged extension cord immediately or have it repaired by a qualified person before using it.

Protect your extension cords from sharp objects, excessive heat, and damp or wet areas.

MINIMUM RECOMMENDED GAUGE FOR EXTENSION CORDS (AWG)			
115 VOLT OPERATION ONLY			
	25' LONG	**50' LONG**	**100' LONG**
0 to 6 Amps	18 AWG	16 AWG	16 AWG
6 to 10 Amps	18 AWG	16 AWG	Not recommended
10 to 12 Amps	16 AWG	16 AWG	Not recommended

UNPACKING & INVENTORY

CHECKING CONTENTS

This mortiser will require some amount of assembly.

Remove all protective materials and coatings from the parts. The protective coatings can be removed by spraying WD-40 on a part and wiping it off with a soft cloth. This may need to be redone several times before all of the protective coatings are removed completely.

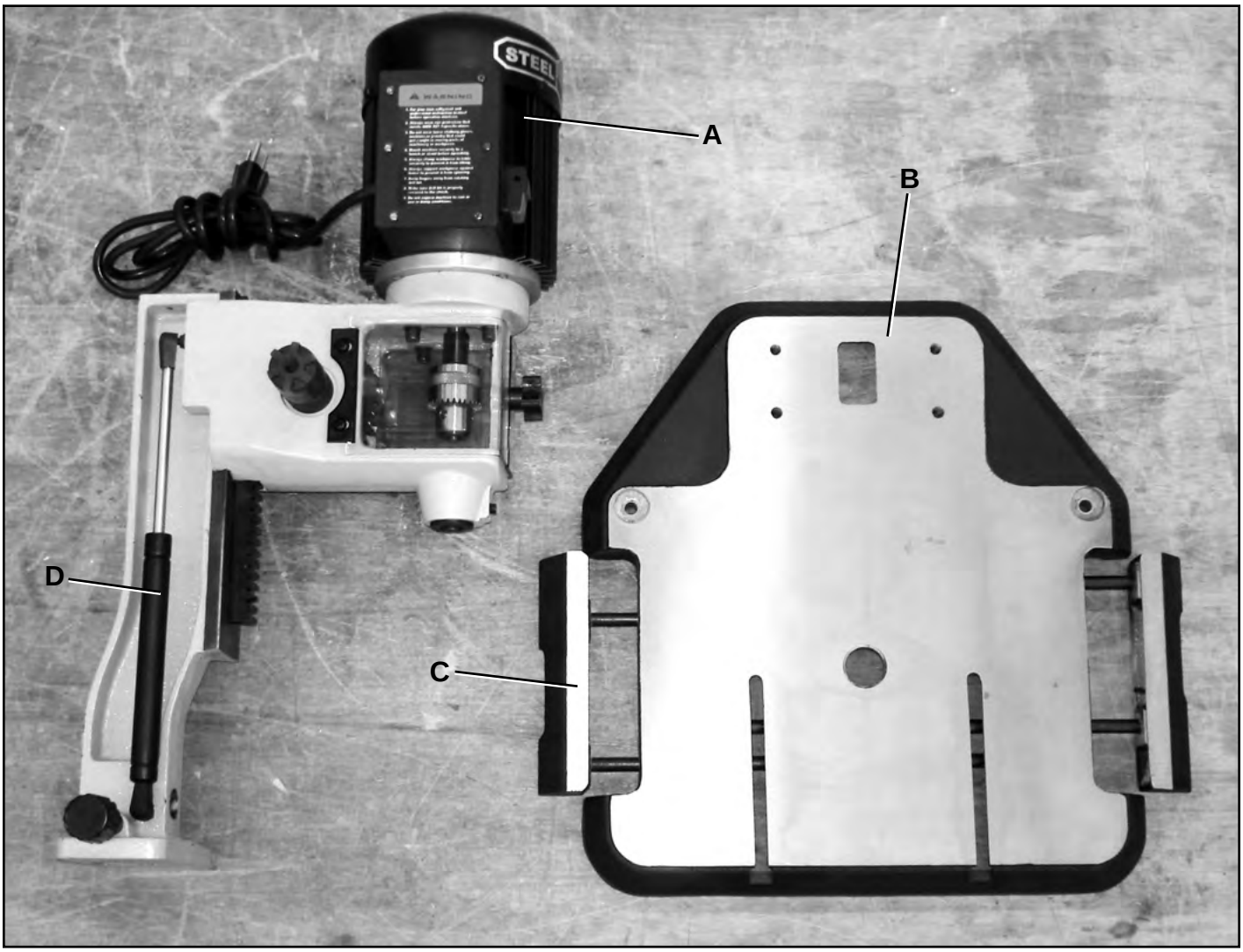
CAUTION: DO NOT use acetone, gasoline or lacquer thinner to remove any protective coatings.

After cleaning, apply a good quality paste wax to any unpainted surfaces. Make sure to buff out the wax before assembly.

Remove all of the parts from the shipping box and lay them on a clean work surface. Compare the items to inventory figures and verify that all items are accounted for before discarding the shipping box.

⚠ WARNING

To avoid serious injury, do not attempt to plug in the power cord and turn "ON" the mortiser if any parts are missing. The mortiser should only be turned "ON" after all the parts have been obtained and installed correctly. **For missing parts, contact Steel City at 1-877-SC4-TOOL.**

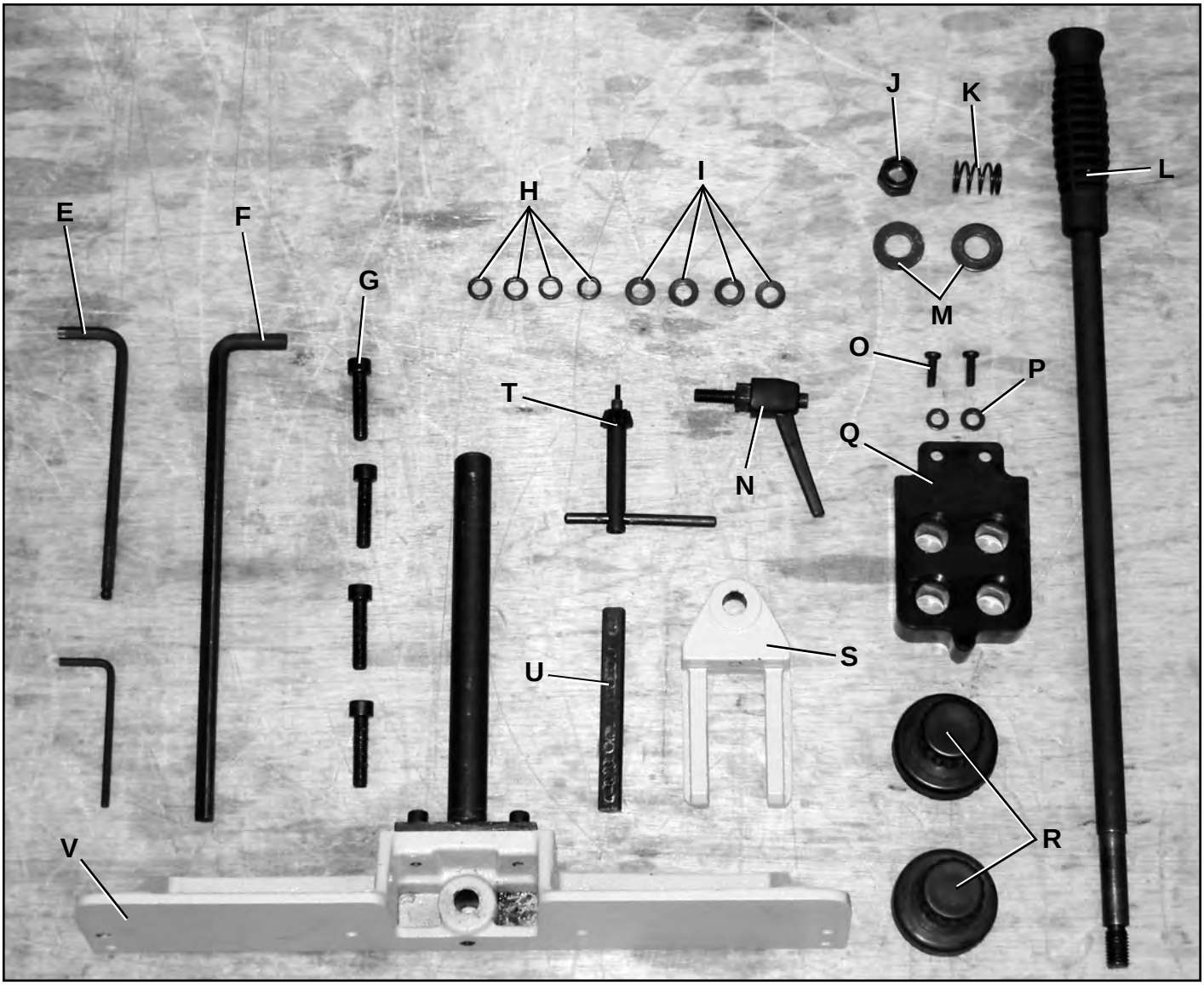


A) Mortiser

B) Base

C) Extension Wings (2)

D) Stabilizer



E) Hex wrench (2)
F) Depth stop rod
G) M8 x 35mm hex socket head screw (4)
H) M8 lock washer (4)
I) M8 flat washer (4)
J) M12 Handle lock nut
K) Handle spring
L) Handle
M) M12 flat washer (2)
N) Fence lock handle
O) M5 x 12mm pan head screw (2)
P) M5 flat washer (2)
Q) Chisel holder
R) Stock rollers
S) Holddown
T) Chuck key
U) Guide rod
V) Fence

ASSEMBLY

⚠WARNING

1. **DO NOT** assemble the Mortiser until you are sure the tool is disconnected from the power source.
2. **DO NOT** assemble the Mortiser until you are sure the power switch is in the off position.

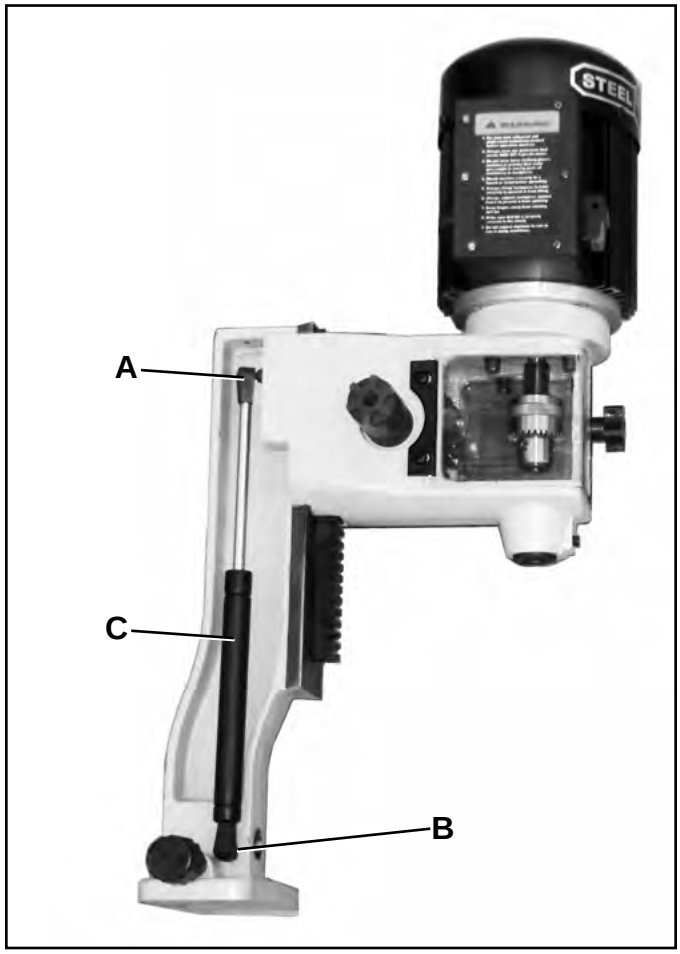
HYDRAULIC CYLINDER ASSEMBLY

⚠WARNING

MAKE CERTAIN THAT THE MORTISER IS DISCONNECTED FROM THE POWER SOURCE.

1. Thread lower ball stud fitting into hole (B) in the column of the Mortiser. **SEE FIG. 5**

Fig. 5



2. Snap the hydraulic cylinder (C) over the upper ball stud fitting (A) on the back of the Mortiser head.
3. Attach the other end of the hydraulic cylinder to the lower ball stud fitting installed in step 1.

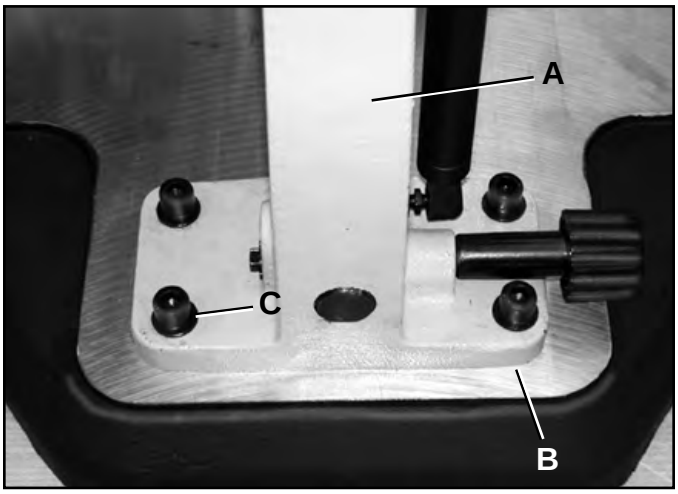
BASE ASSEMBLY

⚠WARNING

MAKE CERTAIN THAT THE MORTISER IS DISCONNECTED FROM THE POWER SOURCE.

1. Place mortiser column (A) over the base (B), aligning the four holes in the mortiser column with the four holes in the base. **SEE FIG. 6.**

Fig. 6



2. Insert four M8 socket head cap screws (C) with washers and lockwashers through the column. Thread into base and tighten.

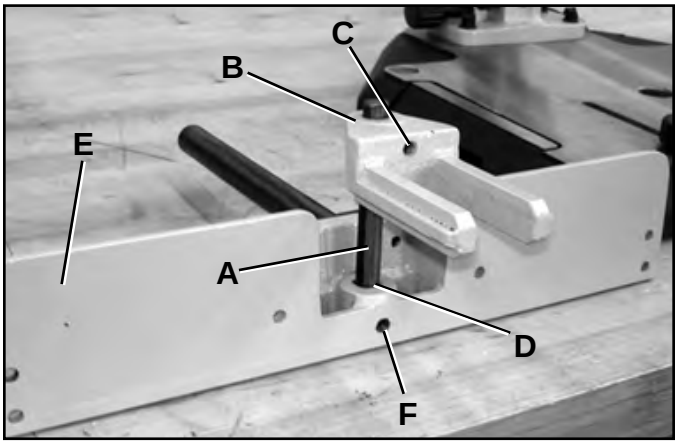
FENCE ASSEMBLY

⚠WARNING

MAKE CERTAIN THAT THE MORTISER IS DISCONNECTED FROM THE POWER SOURCE.

1. Insert guide rod (A) through hole in hold down (B) and tighten set screw (C) using supplied hex wrench. **SEE FIG. 8.**

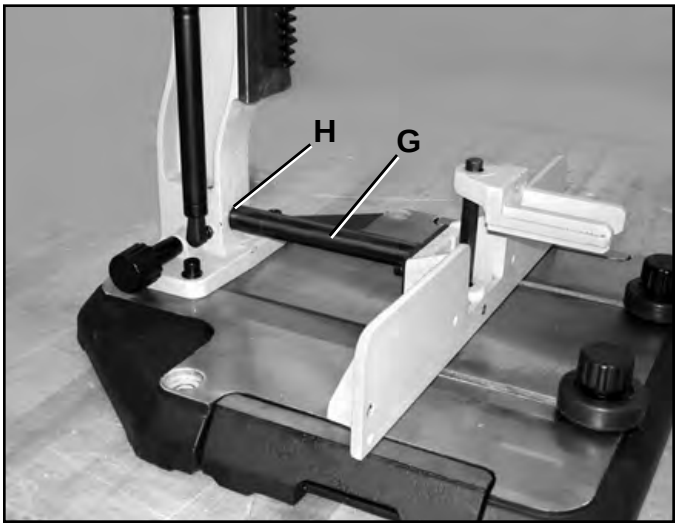
Fig. 8



2. Insert guide rod into hole (D) of fence assembly (E) and tighten set screw (F) using supplied hex wrench.

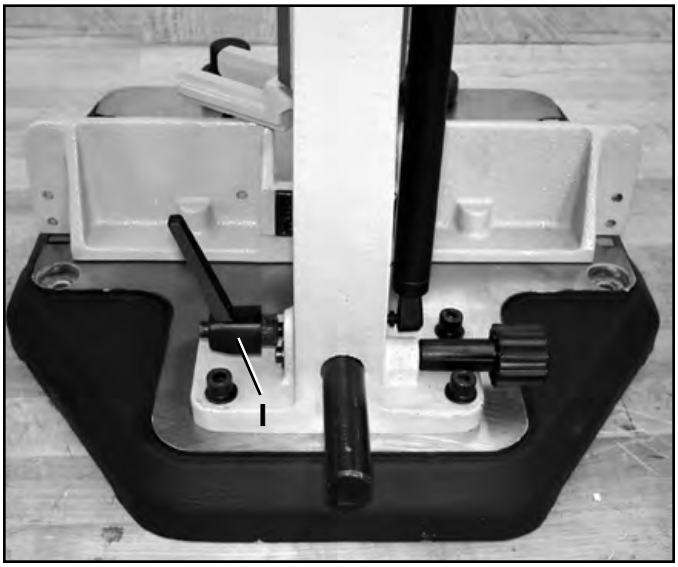
3. Insert fence guide shaft (G) through hole (H) in column of the mortiser. **SEE FIG. 9.**

Fig. 9



4. Thread fence lock handle (I) into the column of the mortiser. Place flat washer over the shaft and secure with phillips head screw. Tighten to secure fence. **SEE FIG. 10.**

Fig. 10



NOTE: Fence lock handle is spring loaded and can be repositioned by pulling out on the handle and rotating it.

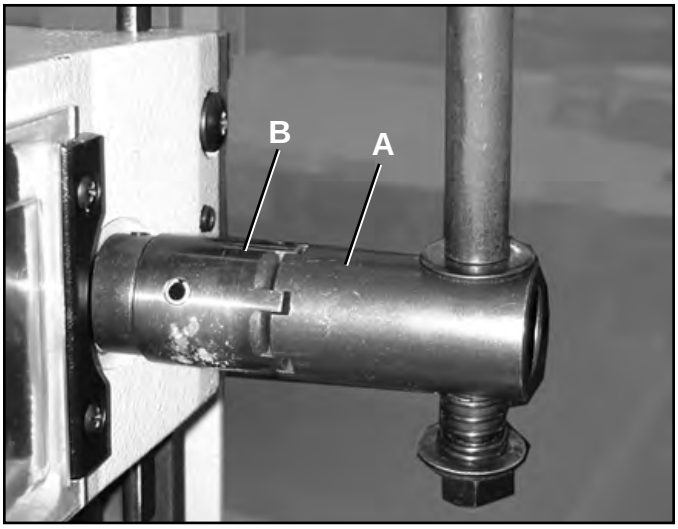
RAISING/LOWERING HANDLE

⚠WARNING

MAKE CERTAIN THAT THE MORTISER IS DISCONNECTED FROM THE POWER SOURCE.

1. Line up the notches in the hub on the handle (A) with the slots in the gear shaft (B). **SEE FIG. 11.**

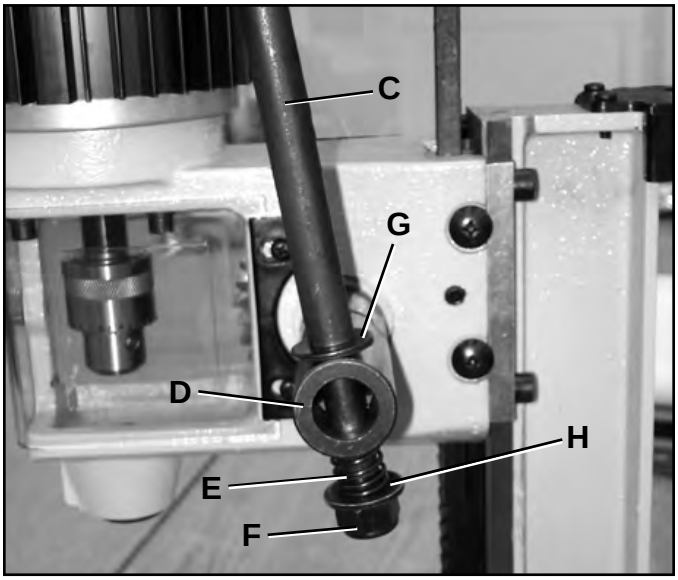
Fig. 11



NOTE: The handle may be attached to either the left side or the right side, depending on your preference.

2. Insert handle (C) with flat washer (G) installed through the hub (D). Place spring (E) over the handle. Place the second flat washer (H) on the handle and thread hex nut (F) onto the handle. **SEE FIG. 12.**

Fig. 12



NOTE: The handle is spring loaded. You can reposition it by pulling it out and repositioning it on the gear shaft.

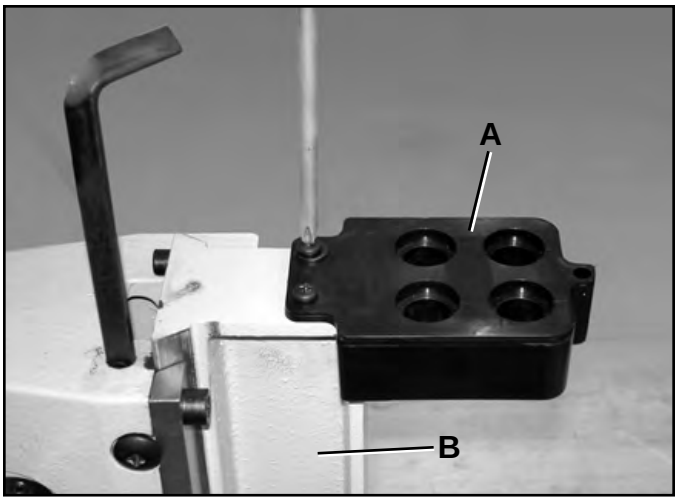
TOOL AND CHISEL HOLDER

⚠WARNING

MAKE CERTAIN THAT THE MORTISER IS DISCONNECTED FROM THE POWER SOURCE.

Place tool and chisel holder (A) on top of column (B) and align with mounting holes. Using two screws and two washers provided, tighten holder to top of column. **SEE FIG. 13.**

Fig. 13



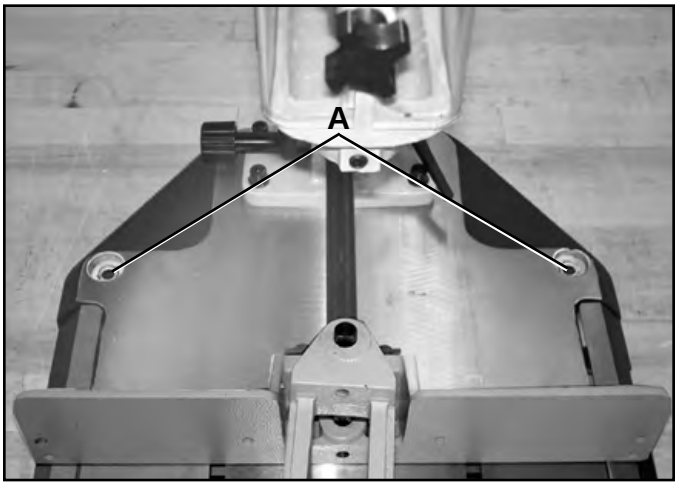
FASTENING MACHINE TO SUPPORTING SURFACE

⚠WARNING

MAKE CERTAIN THAT THE MORTISER IS DISCONNECTED FROM THE POWER SOURCE.

If during operation there is any tendency for the mortiser to tip over, slide, or walk on the supporting surface, the base must be secured to the supporting surface with fasteners (not supplied), through the two holes (A) located in the mortiser base. **SEE FIG. 14.**

Fig. 14



INSTALLING CHISEL AND BIT

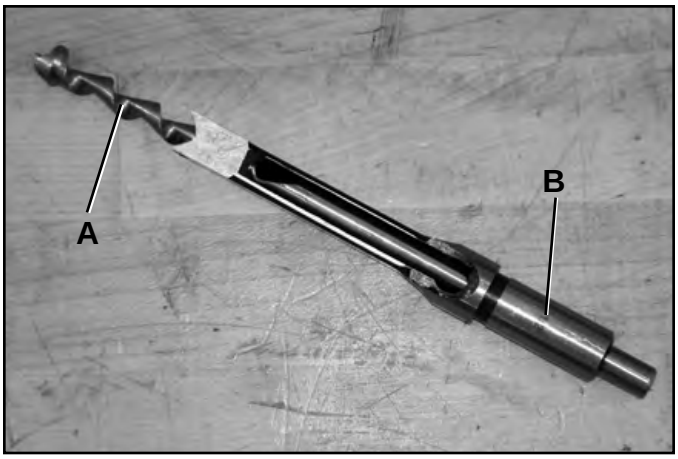
⚠WARNING

MAKE CERTAIN THAT THE MORTISER IS DISCONNECTED FROM THE POWER SOURCE.

CHISELS ARE VERY SHARP AND CAN CAUSE A SERIOUS CUT. TAKE EXTREME CAUTION WHEN HANDLING CHISELS.

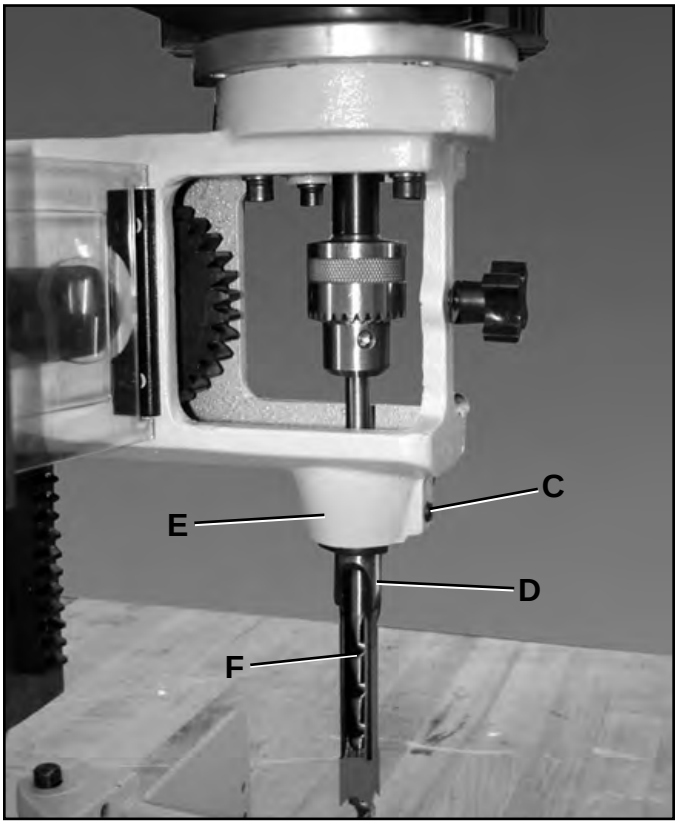
1. Insert bit (A) into chisel (B). **SEE FIG. 15.**

Fig. 15



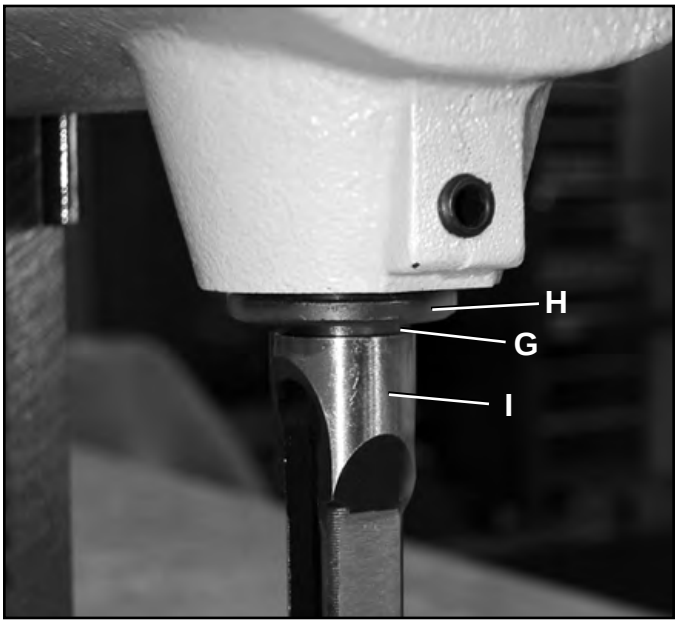
2. Loosen set screw (C) and push chisel (D) up through hole in head (E) as far as possible, making sure that the opening in the chisel (F) is facing left or right. **SEE FIG. 16.**

Fig. 16



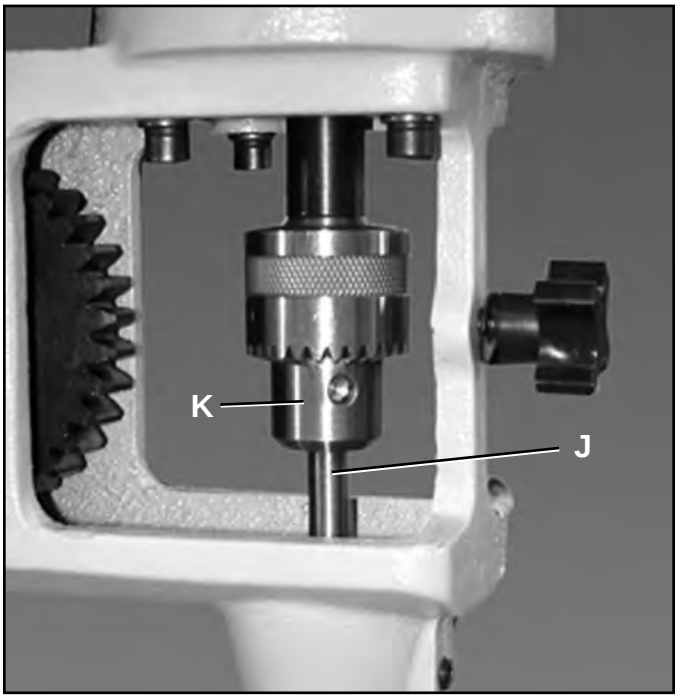
3. Lower chisel 1/16” to 3/16” and tighten set screw. There must be a space of 1/16” to 3/16” clearance (G), about the thickness of a dime, between the bushing (H) and shoulder of chisel (I). This assures having proper clearance between the cutting edges of the bit and points of the chisel after the bit is inserted into the chuck. **SEE FIG. 17.**

Fig. 17



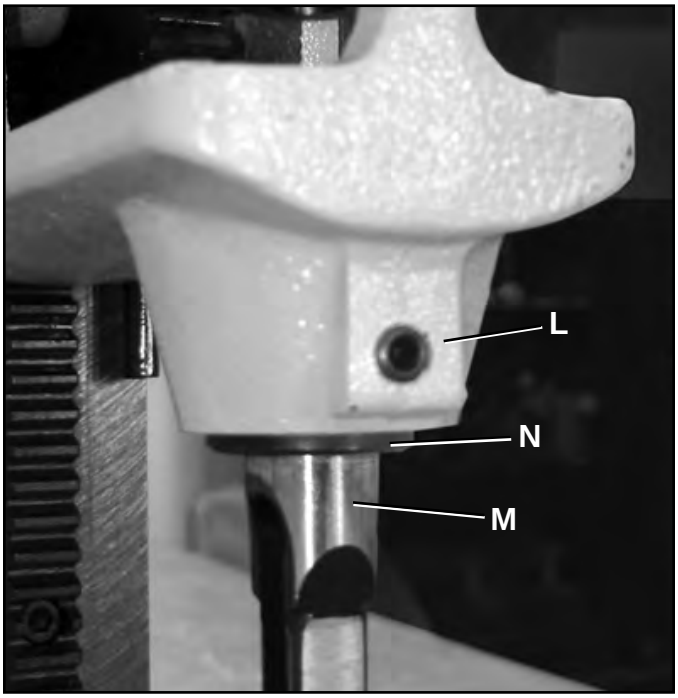
4. Push bit (J) up through the chisel and into the chuck (K) until the bottom of the bit is flush with the bottom of the chisel. Lock bit into the chuck using the supplied chuck key. **SEE FIG. 18.**

Fig. 18



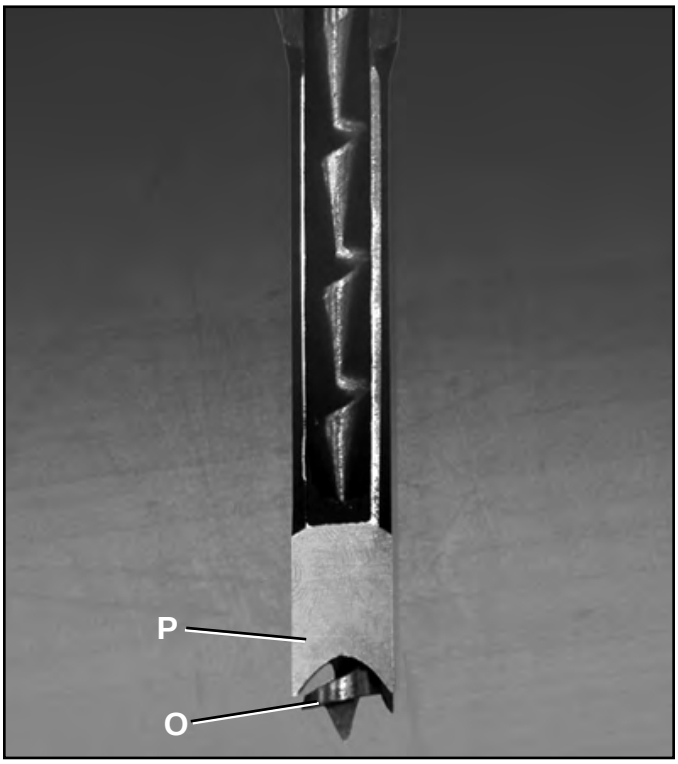
5. Loosen set screw (L), push chisel (M) up against the bottom of bushing (N) and tighten set screw. This should provide the proper distance between the cutting edges of the bit and points of the chisel. **SEE FIG. 19.**

Fig. 19



6. The flat portion of the bit (O) should now be adjusted to a minimum of 1/16” below the bottom of the chisel (P). For certain types of wood it may be necessary to increase this distance to a maximum of 3/16” clearance. **SEE FIG. 20.**

Fig. 20

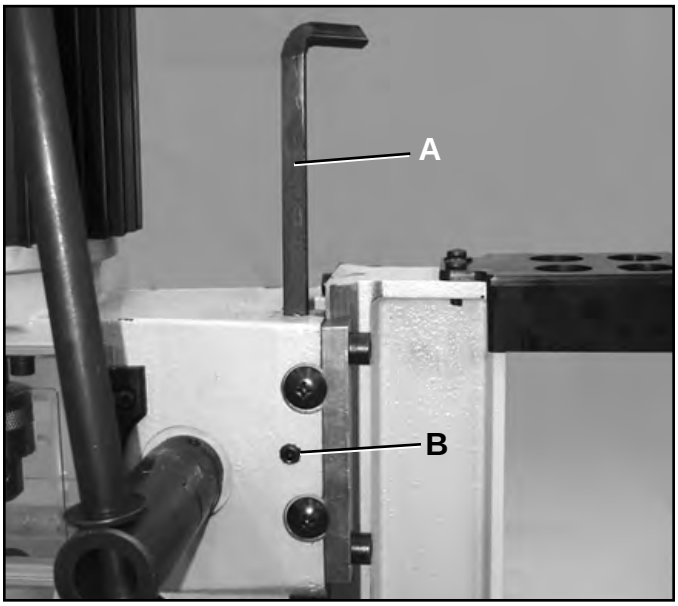


ADJUSTMENTS

DEPTH STOP ROD

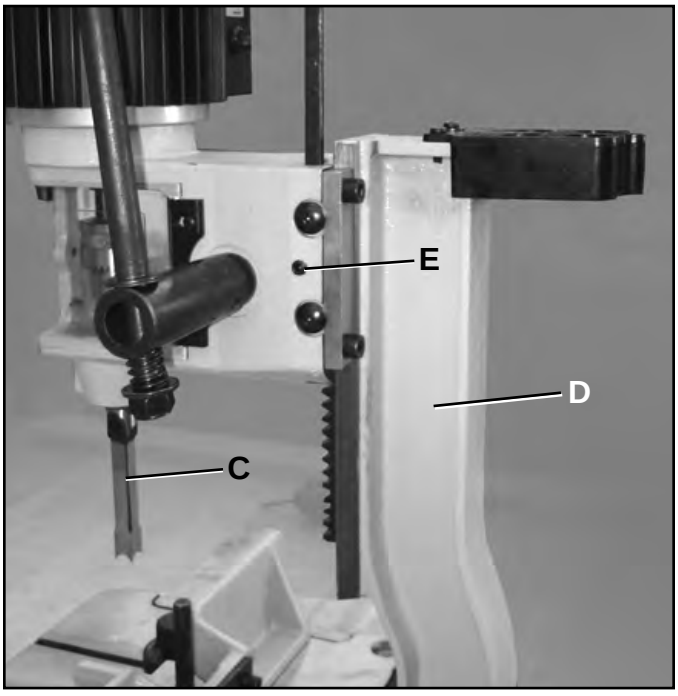
The depth stop rod is provided to limit the cutting depth of the chisel. To adjust the depth stop rod (A), loosen set screw (B). **SEE FIG. 23.**

Fig. 23



1. Lower head until the cutting chisel (C) is at the desired depth. **SEE FIG. 24.**

Fig. 24



2. Lower depth stop rod until it contacts the top of the column (D).
3. Tighten set screw (E).

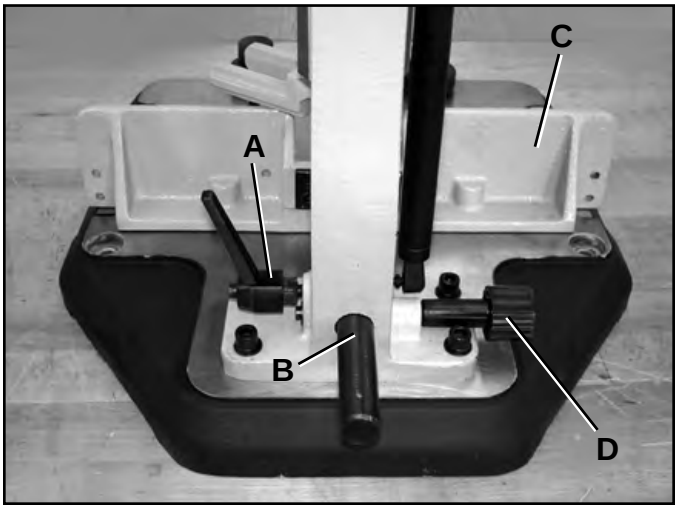
FENCE

The fence can be moved in or out to accommodate various size workpieces.

To move fence:

1. Loosen fence lock handle (A) until the fence glide shaft (B) can move freely. **SEE FIG. 25.**
2 Slide fence (C) in or out to the desired position.
3. Tighten fence lock handle to secure fence.

Fig. 25



MICRO-ADJUST ASSEMBLY

Sometimes it is necessary to move the fence in small increments. When this is the case, the micro-adjust assembly should be used.

1 Loosen the fence lock handle (A) so that the fence (C) may slide smoothly. **SEE FIG. 25.**
2. Rotate the adjustment knob (D) clockwise to move the fence in towards the mortiser column. Rotate counterclockwise to move the fence away from the mortiser column.

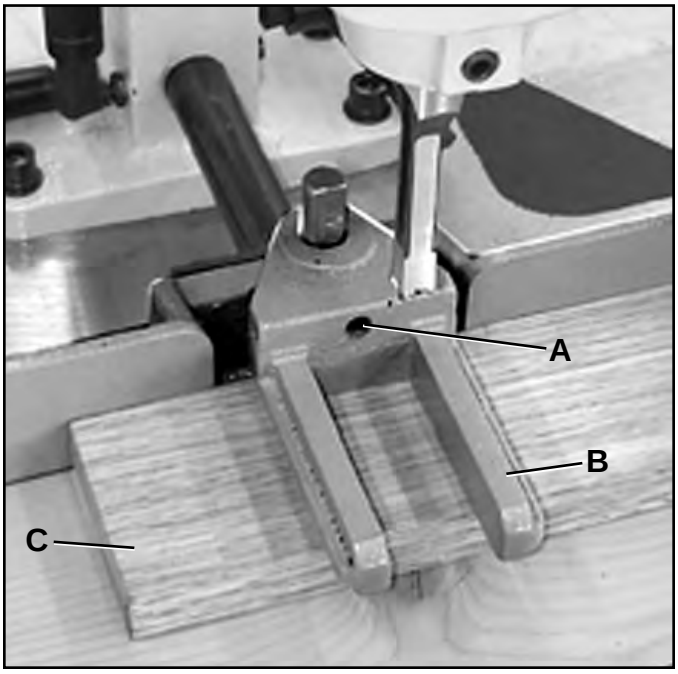
HOLDDOWN

The purpose of the holddown is to prevent the workpiece from lifting as the chisel is raised up.

To adjust: Loosen set screw (A), position holddown (B) until it just touches the top of the workpiece (C) and allows the workpiece to slide left or right. Once holddown is in position, retighten set screw. **SEE FIG. 26.**

NOTE: The holddown can also be turned upside down to accommodate thicker workpieces. When doing this, tighten the set screw on the back side of the holddown. **SEE FIG. 26.**

Fig. 26



SETTING CHISEL SQUARE TO FENCE

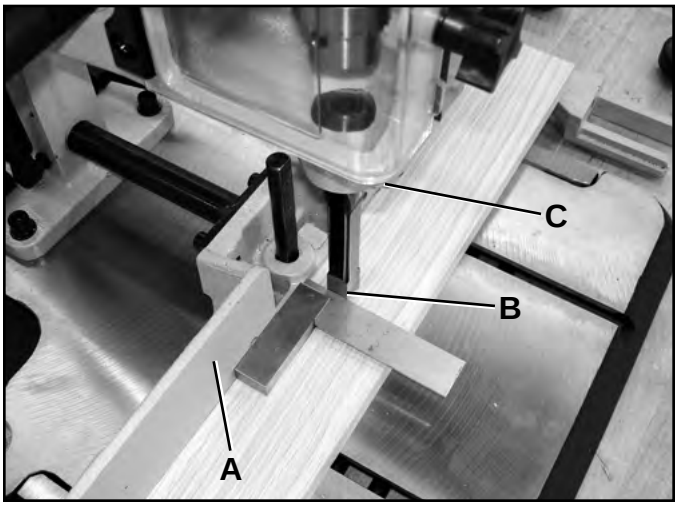
⚠WARNING

MAKE CERTAIN THAT THE MORTISER IS DISCONNECTED FROM THE POWER SOURCE.

Checking that chisel is square to fence:

1. Place a square against the face of the fence (A). **SEE FIG. 27.**
2. Check to see if left side of chisel (B) is square to the face of the fence.
3. If not square, loosen set screw (C) and reposition chisel until the left side of the chisel is flat against the square.
4. Retighten set screw.

Fig. 27

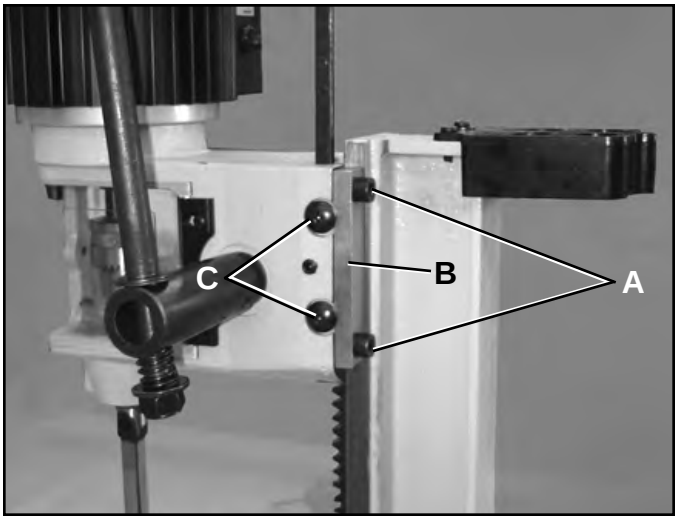


SLIDING FIT BETWEEN HEAD AND COLUMN

A dovetail gib is provided on the rear of the head to insure a good sliding fit between the head and the column when the head is raised and lowered. This should be set at the factory and should not need adjustment. If adjustment is necessary, perform the following steps.

1. Loosen two socket head cap screws (A) in the dovetail gib (B) only slightly (less than 1/8 turn) using provided hex wrench. **SEE FIG. 28.**

Fig. 28



2. Turn adjusting screws (C) clockwise to make a tighter fit, turn counterclockwise for a looser fit.

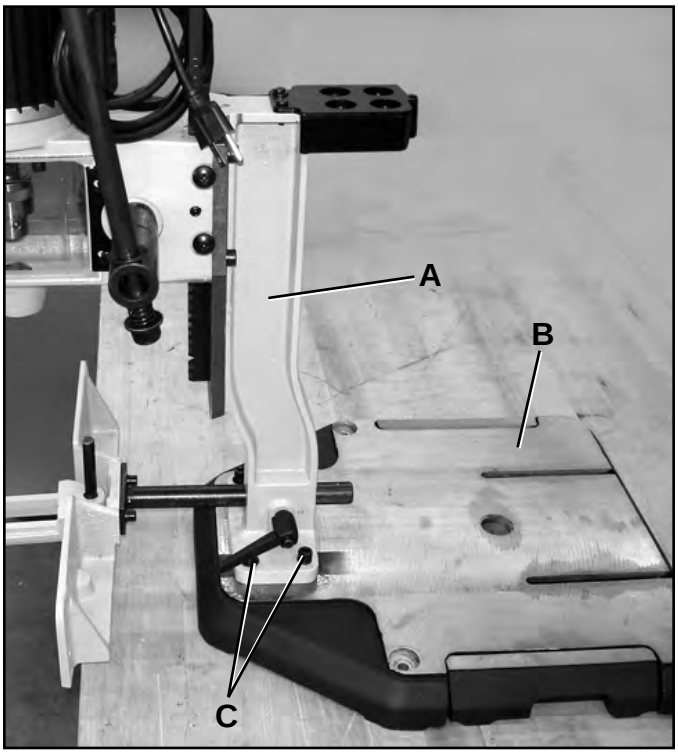
NOTE: Correct adjustment is when a good snug sliding fit is obtained without any side movement between the gib and the column. This adjustment should not be too tight that it restricts the sliding movement or too loose that it affects accuracy.

3. Once proper fit is achieved, retighten the two socket head cap screws.

ROTATING COLUMN 180 DEGREES

Sometimes a workpiece may be too large to fit between the base and the chisel. When this is the case, you can rotate the column of the mortiser 180 degrees, as shown, and perform the work off of a bench or floor.

Fig. 29



⚠WARNING

When rotating column 180 Degrees, you **MUST** fasten the machine to a supporting surface. See FASTENING MACHINE TO SUPPORTING SURFACE in the ADJUSTMENTS section of this manual.

1. To rotate the column, remove the four M8 socket head cap screws (C) that bolt the mortiser column (A) to the base (B). **SEE FIG. 29.**
2. Rotate column 180 degrees.
3. Replace four M8 socket head cap screws (C).

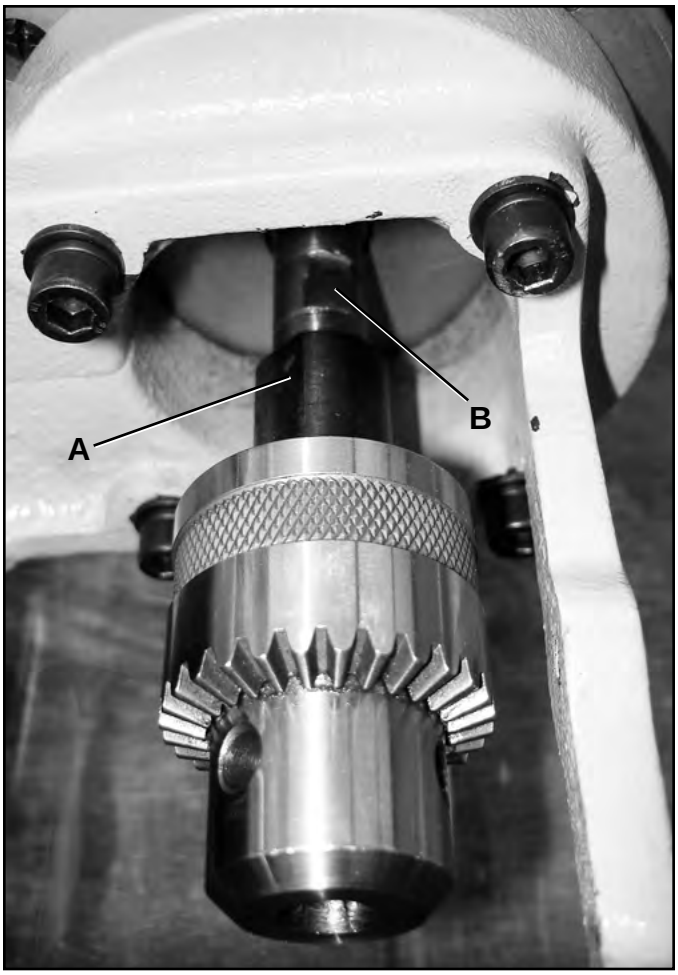
USING BITS WITH EXTRA LONG SHANKS

When using bits with extra long shanks, it will be necessary to remove the extension.

⚠WARNING

MAKE CERTAIN THAT THE MORTISER IS DISCONNECTED FROM THE POWER SOURCE.

Fig. 30



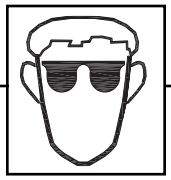
1. Remove the mortising bit.
2. Place one open end wrench on the flats of the extension (A) and one open end wrench on the flats of the motor shaft (B) (wrenches not supplied).
3. Unscrew the extension and chuck from the motor shaft.
4. Remove the chuck from the extension.
5. Reinstall the chuck to the motor shaft. Tighten securely.

OPERATIONS

⚠ WARNING

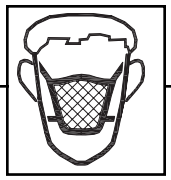
MAKE CERTAIN THAT THE MORTISER IS DISCONNECTED FROM THE POWER SOURCE.

⚠ WARNING



ALWAYS wear eye protection. Any machine can throw debris into the eyes during operations, which could cause severe and permanent eye damage. Everyday eyeglasses are **NOT** safety glasses. **ALWAYS** wear Safety Goggles (that comply with ANSI standard Z87.1) when operating power tools.

⚠ WARNING

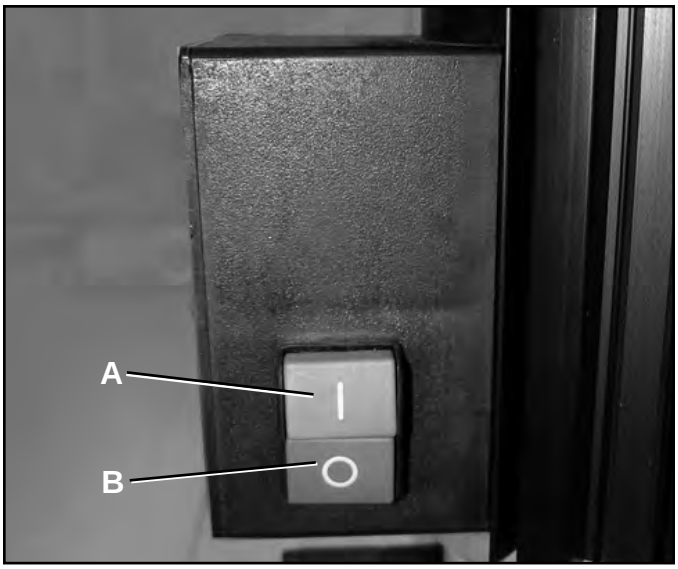


ALWAYS wear a NIOSH/OSHA approved dust mask to prevent inhaling dangerous dust or airborne particles.

ON/OFF SWITCH

The switch is located on the side of the motor. To turn the machine on, push the green button (A). To turn the machine off, push the red button (B). **SEE FIG. 31.**

Fig. 31

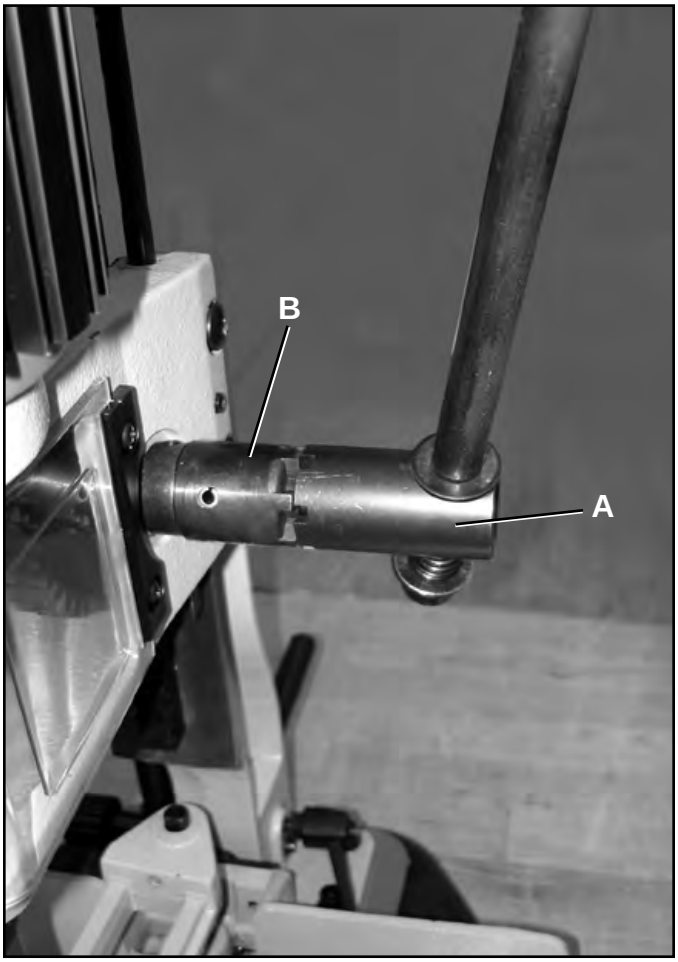


When the tool is not in use, the tool should be locked in the OFF position to prevent unauthorized use. This can be done by placing a padlock (not provided) through the hole in the green button.

RAISING AND LOWERING THE HEAD

The head is raised and lowered by using the handle. For maximum leverage during the mortising operation, the handle can be repositioned by pulling out the hub (A) of the handle assembly and repositioning hub on the pinion shaft (B). **SEE FIG. 32.**

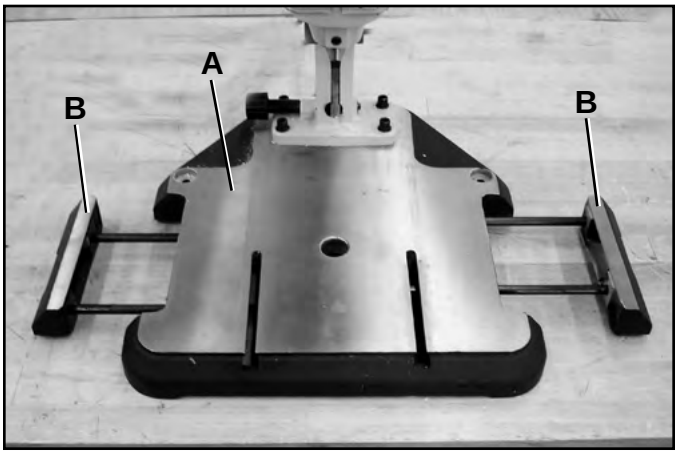
Fig. 32



EXTENSION WINGS

The mortiser base (A) is equipped with two extension wings (B), one on each side of base. They are used when working with longer workpieces, to add stability to the operation. **SEE FIG. 33.**

Fig. 33

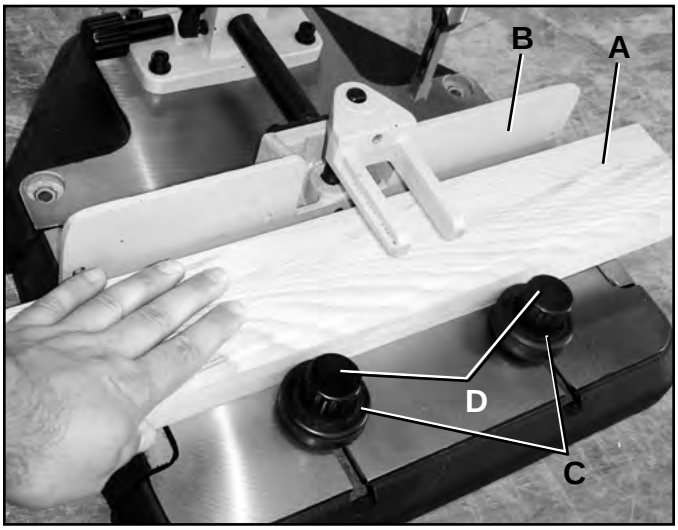


STOCK ROLLERS

The stock rollers are a convenience feature that helps keep the workpiece pressed firmly against the fence. To set up:

1. Press workpiece (A) firmly up against the fence (B). **SEE FIG. 33A**.

Fig. 33A



2. Loosen stock rollers (C) by turning each knob (D) counterclockwise.
3. Slide the stock rollers so that they are pressed firmly up against the workpiece.
4. Tighten the knobs on the stock rollers by turning them clockwise.

NOTE: Make sure that the rollers are pressed against the workpiece firmly enough to keep it from pulling away from the fence, but not so tight that the workpiece cannot slide freely from left to right.

USING AUXILIARY WOOD FENCE

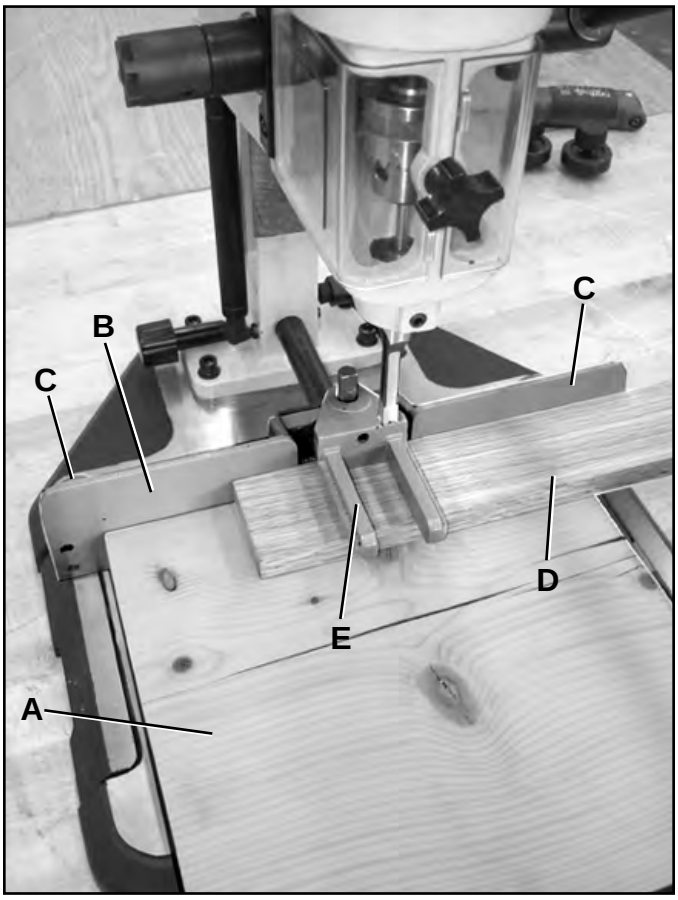
When mortising an extra high workpiece, an auxiliary fence can be fastened to the fence with wood screws (not provided) through the holes in the fence. This provides additional support for the workpiece during mortising operation.

USING SACRIFICIAL BOARD

When performing a through mortise, it is a good practice to use a sacrificial board to prevent any chipout at the bottom of the mortise.

1. To attach a sacrificial board, place sacrificial board (A) against the face of the fence (B). **SEE FIG. 34.**

Fig. 34



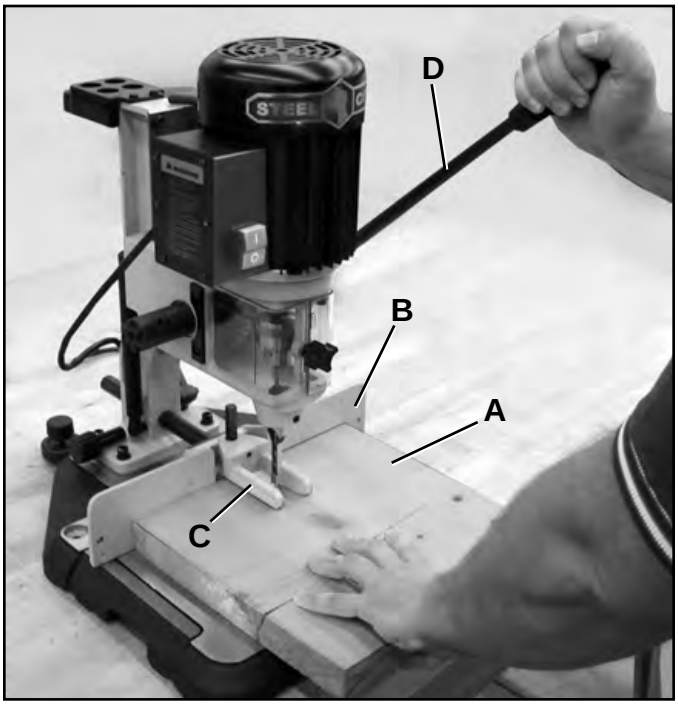
2. Attach sacrificial board to fence using wood screws (not provided) though the holes of the fence (C).
3. Place workpiece (D) on top of sacrificial board and up against the fence.
4. Fasten workpiece using the holddown (E).

NOTE: When using sacrificial board, **DO NOT** use the stock rollers.

OPERATING THE MORTISER

1. Make sure that the workpiece (A) is held firmly against the fence (B) when cutting and that the holddown (C) is properly adjusted. **SEE FIG. 35.**

Fig. 35



2. Using the Raise/Lower handle (D), lower the chisel until it penetrates the workpiece.

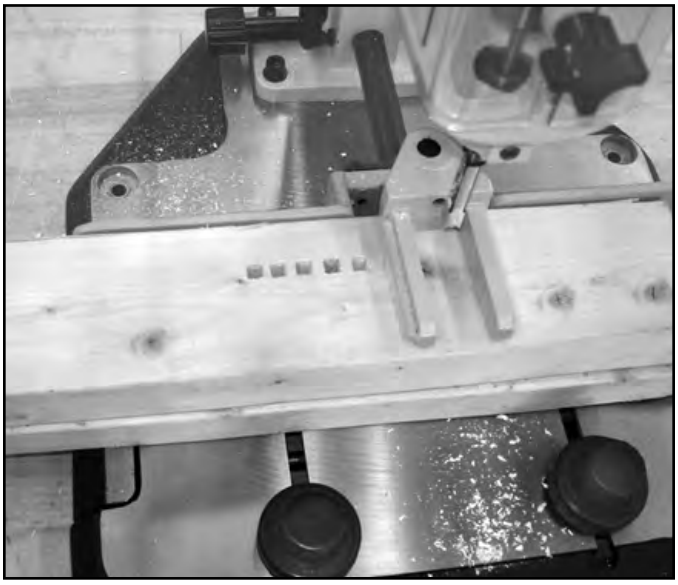
NOTE: The rate of penetration of the chisel must be fast enough to prevent burning at the tip of the bit, but not too fast as to stall the motor.

NOTE: You may encounter smoke from the bit or material once the chisel has engaged the material. The smoke created is a natural operating occurrence in hollow chisel mortising and is caused by material chip friction and the resins in the stock being burned off.

NOTE: Retract drill bit frequently during drilling operations to help clear chips from the hole.

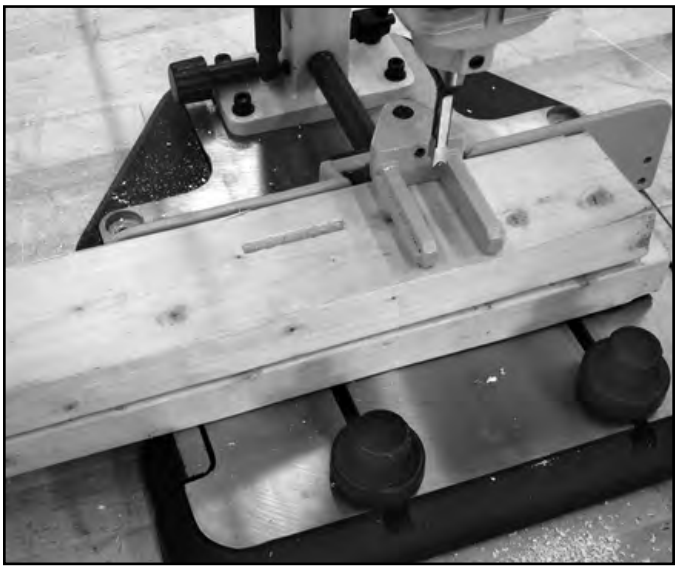
3. When making additional penetrations, leave a gap between the holes. **SEE FIG. 36.**

Fig. 36



4. Once the desired length of the mortise is achieved, go back and chisel out the remaining gaps. This will ensure a smooth, clean mortise. **SEE FIG. 37.**

Fig. 37



NOTE: A blue-tinted chisel is not indicative of a dull chisel, but a combination of friction and resin buildup on the cutting faces of the chisel. A dull chisel can be detected by the amount of excess force required to complete a cut.

MAINTENANCE

Repairs to this power tool should be performed by trained personnel only. Contact your nearest Steel City Service Center for authorized service. Unauthorized repairs or replacement with non-factory parts could cause serious injury to the operator and damage to your machine.

⚠ WARNING

To prevent injury to yourself or damage to the machine, turn the switch to the “OFF” position and unplug the power cord from the electrical receptacle before making any adjustments.

The Mortiser will operate best if it is kept in proper operating condition. Keep unit adjusted as described in OPERATIONS AND ADJUSTMENTS.

- Turn the power switch “OFF” and unplug the power cord from its power source.
- Do not allow gum and pitch to accumulate on cutting tool.
- Do not allow chips to accumulate on or around the machine.
- Keep chisels and bits sharp. Keeping a spare set of chisels and bits on hand is recommended. Contact your Steel City Distributor for replacement parts.

⚠ WARNING

DO NOT USE FLAMMABLE MATERIALS to clean this machine. A clean dry rag or brush is all that is needed to remove dust and debris buildup.

PROTECTING CAST IRON TABLE FROM RUST

⚠ WARNING

MAKE CERTAIN to turn the switch "OFF" and unplug the power cord from its power source.

The environment and frequency of human contact can have a very detrimental impact on unpainted cast iron surfaces. Moisture, humidity and oils (from human hands!) can cause the unpainted cast iron surfaces to mar or rust, so it is important to conduct routine maintenance to keep your mortiser looking new. Cleaning and waxing the cast iron surfaces on a regular maintenance schedule is recommended as follows:

To clean and maintain the unpainted cast iron surfaces:

- Apply a heavy coat of WD-40 onto the unpainted cast iron surface.
- Use a fine steel wool pad to buff the unpainted cast iron. Make sure to buff in a "front to rear" direction only. A side-to-side buffing motion will show in the finely ground cast iron as a flaw, defect or scratches.
- Reapply WD-40 and buff the unpainted cast iron surfaces until the stain is removed. Make sure you use the same front-to-rear buffing direction to avoid scratching or marring the cast iron surface.
- After all stains and/or rust have been removed, clean all oil and dirt from the surface using a soft cloth or rag.
- Lastly, you need to apply a good automotive paste wax to all unpainted cast iron surfaces. This will help to protect the surface from rusting from further contact with moisture or oily hands.

LUBRICATION

The Mortiser has sealed lubricated bearings in the motor housing that do not require any additional lubrication from the operator.

- Fence guide and elevation screws should be cleaned of debris and greased as needed.
- Occasionally apply a few drops of light machine oil to gibs to keep tables free in relation to base.

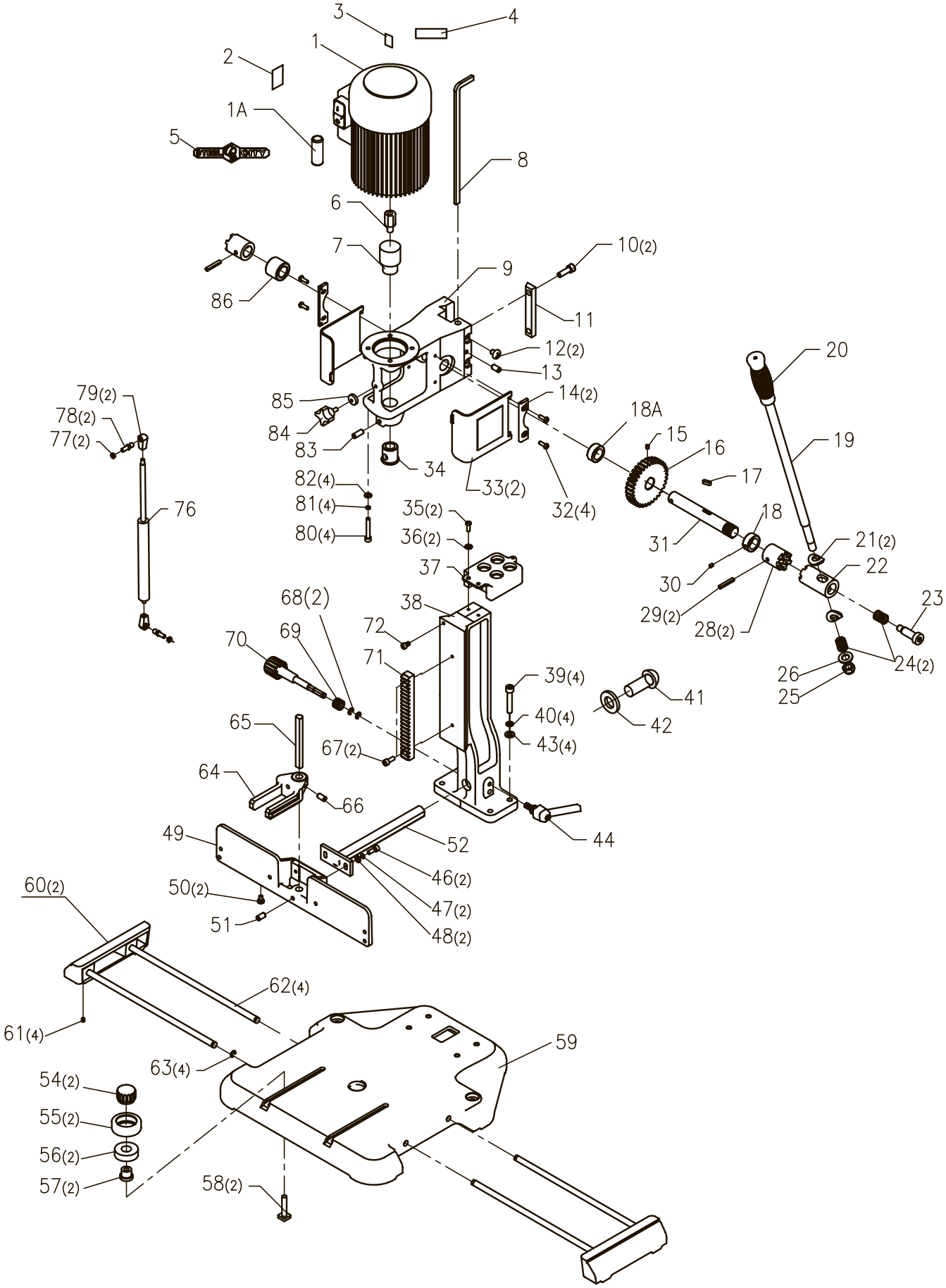
TROUBLESHOOTING GUIDE

TO PREVENT INJURY TO YOURSELF or damage to the mortiser, turn the switch to the OFF position and unplug the power cord from the electrical receptacle before making any adjustments.

PROBLEM	LIKELY CAUSE(S)	SOLUTION
Motor does not start or does not come up to full speed	1. Defective switch 2. Defective capacitor 3. Low line voltage 4. Defective motor	1. Have switch replaced. 2. Have capacitor replaced. 3. Correct low line voltage condition. If machine is plugged into an extension cord, disconnect and plug directly into wall outlet. 4. Have motor replaced. NOTE: 2, 3, and 4 must be done by a qualified service technician; Consult Steel City Tool Works service.
Motor stalls or circuit breakers open frequently	1. Circuit overload 2. Low line voltage 3. Motor overload 4. Incorrect fuses on circuit breakers 5. Short circuit in motor; loose connections or worn insulation on lead wires.	1. Reduce circuit load (turn off other appliances). 2. Correct low line voltage condition. Check line voltage with a multi-meter. If mortiser is plugged into an extension cord, unplug mortiser from extension cord and plug mortiser directly to wall outlet. 3. Reduce load on motor, slow down feed rate. 4. Have correct fuses on circuit breakers installed by a qualified electrician. 5. Inspect terminals in motor for damaged insulation and shorted wires and have them replaced. Check all power lead connections.
Motor running too hot	1. Restricted air circulation due to dust accumulation. 2. Motor overload	1. Clean dust and restore normal air circulation around motor. 2. Reduce load on motor, slow down feed rate.
Drill bit stalls or slips	1. Drill bit is not securely tightened in chuck.	1. Install drill bit properly. See ASSEMBLING CHISEL AND BIT in ASSEMBLY INSTRUCTIONS.
Drill bit or material smokes or burns	1. Chips not exiting out of drill hole. 2. Dull drill bit.	1. Retract drill bit frequently during drilling operation to clear chips from hole. 2. Replace or sharpen drill bit.
Excessive drill bit runout or wobble	1. Bent drill bit. 2. Drill bit not properly installed in chuck.	1. Replace with a straight or new drill bit. 2. Install drill bit properly. See ASSEMBLING CHISEL AND BIT in ASSEMBLY INSTRUCTIONS.

◆ NOTES ◆

PARTS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KEY NO.	PART NO.	DESCRIPTION	QTY.
1	OR71540	Motor Assy. Inc. Ref. 2,3,4,5	1
1A	OR71540A	Capacitor	1
2	OR71541	Warning Label	1
3	OR71542	Spec Label	1
4	OR71543	Motor Label	1
5	OR71544	Logo Label	1
6	OR71545	Link Shaft	1
7	OR71546	3/8” Chuck	1
8	OR71547	Dpth Stop Rod	1
9	OR71548	Head	1
10	OR93381	M8X20 Hex Soc Hd Scr	2
11	OR71549	Guide	1
12	OR94172	M8X10 Pan Screw	2
13	OR91821	M8X20 Set Screw Hex Hd	1
14	OR71550	Hinge	2
15	OR91764	M5X10 Set Screw Skt Hd	1
16	OR71551	Gear	1
17	OR94051	5X5X12 Key	1
18	OR71552	Place Ring	1
18A	OR71552A	Place Ring	1
19	OR71553	Handle Shaft Inc. Ref. 20	1
20	OR71554	Handle	1
21	OR94173	12 Saddle-Backed Washer	2
22	OR71555	Handle Joint	1
23	OR94174	Rotation Shaft Bolt	1
24	OR94175	Spring	2
25	OR94176	M12 Hex Hd Nut Skt	1
26	OR90304	12 Flat Washer	1
28	OR71556	Gear Shaft Joint	2
29	OR94183	6X32 Spring Pin	2
30	OR93906	M5X6 Set Screw Skt Hd	1
31	OR71557	Gear Rod	1
32	OR90505	M5X12 Pan Screw	4
33	OR71558	Cover	2
34	OR71559	Bushing	1
35	OR90505	M5X12 Pan Screw	2
36	OR90462	5 Flat Washer	2
37	OR71560	Chisel Holder	1
38	OR71561	Column	1
39	OR94177	M8X35 Hex Soc Hd Screw	4
40	OR90248	8 Lock Washer	4
41	OR90761	M5X10 Pan Hd Screw	1
42	OR90462	5 Flat Washer	1
43	OR90311	8 Flat Washer	4
44	OR94178	Lock Handle (M8X21)	1
45	OR71566	Fence Assy. Inc. Ref. 46,47,48,49,50,51,52	
46	OR93373	M6X16 Hex Soc Hd Scr	2
47	OR90502	6 Lock Washer	2
48	OR90059	6 Flat Washer	2
49	OR71569	Fence	1
50	OR71596	Fence Glide Pad	2
51	OR93378	M8X10 Set Screw Hex Soc	1
52	OR71567	Fence Glide	1
53	OR71570	Stock Roller Assy. Inc Ref. 54,55,56,57,58	
54	OR71571	Knob	2
55	OR71572	Rubber Wheel	2
56	OR71573	Bush 2	2
57	OR71574	Bush 1	2
58	OR71575	M8X35 T-Screw	2
59	OR71576	Base	1
60	OR71577	Extension Base	2
61	OR90222	M6X10 Set Screw Hex Soc	4
62	OR71578	Extension Bar	4
63	OR94179	8 Open Retaining Ring	4
64	OR71579	Hold down	1
65	OR71580	Guide Rod	1
66	OR93378	M8X10 Set Screw Hex Soc	1
67	OR93951	M6 x 16mm Hex Soc Set Scr	2
68	OR94180	6 Open Retaining Ring	2
69	OR71581	Gear	1
70	OR71582	Adjust Knob	1
71	OR71583	Rack	1
72	OR90222	M6X10 Hex Soc Set Screw	1
75	OR71584	Stabilizer Cylinder Assy. Inc Ref. 76,77,78,79	
76	OR93346	Stabilizer Cylinder	1
77	OR90758	M6 Hex Hd Nut Thin	2
78	OR93348	Junction Screw	2
79	OR93347	Ball Stud	2
80	OR93377	M6X45 Hex Soc Hd Scr	4
81	OR90502	6 Lock Washer	4
82	OR90059	6 Flat Washer	4
83	OR91821	M8X20 Set Screw Hex Hd	1
84	OR94181	Clamp Knob	1
85	OR94182	6 Nylon Washer	1
86	OR71585	Washer	1
87	OR71586	Chisel and Drill Bit Assy. Inc. Ref. 88,89,90,91 (NOT SHOWN)	
88	OR71587	1/4” Chisel and Drill Bit Assy.(CHOOSE)	1
89	OR71588	5/16” Chisel and Drill Bit Assy.(CHOOSE)	1
90	OR71589	3/8” Chisel and Drill Bit Assy. (CHOOSE)	1
91	OR71590	1/2” Chisel and Drill Bit Assy. (CHOOSE)	1
92	OR71591	4MM Hex Wrench (NOT SHOWN)	1
93	OR71592	6MM Hex Wrench (NOT SHOWN)	1
94	OR71593	Instruction Manual (NOT SHOWN)	1
95	OR71594	Instruction Manual, Spanish (NOT SHOWN)	1
96	OR71595	Instruction Manual, French (NOT SHOWN)	1
97	OR93352	Chuck Key (NOT SHOWN)	1
98	SC10547	T-Handle (NOT SHOWN)	1

◆ NOTES ◆

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2 *Year Warranty*